



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11696	34/50
2	Machined By		V. T. L. H/c Shop	Drg. No. 1.3.0.578
3	Pallet Die No.		12066 (2.8) H/c	Rev: 01
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/c Step 0.0, 615.3 H/c	Tapper = 4°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 2 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping at of holes = 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.7 H/c	Tapping Depth 19.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/4/24

1	As per programme no.		_____	
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 240
2	External Relief Dia	2.3 H/c	Outside (2-3)		Inner			
3	External Relief Depth		22 H/c		16 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		15	4	24			

Inspected By (Sign) & Date

Ravi 15/4/24

Reviewed by (Engineer-CNC)

Manager-QA