



Lark Engineering Company (India) Pvt. Ltd.

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

7332

Form No. CNC/QA/FM/02
 Rev. No. 01
 Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11709/	25/55/
3	Pallet Die No.		V.T.L. H/C Shop	Drg No. L.E.C2/4984
4	Die Category	Drg. No.	11947 (5.0) H/C	Rev: 0
5	Out Side Diameter	Drg. No.	8 x 29 wide	
6	Inside Diameter	Drg. No.	6.30 H/C Step OD: 6.12 H/C	Step length = 19.5
7	Width of Pellet Die	Drg. No.	5.80 H/C	
8	Grooves as per Drawing	Drg. No.	2.82 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 H/C 13 x 8 x 5 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		5.65 H/C	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 2.7 H/C	Tapping Depth = 18.8 H/C
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Rasi 17/4/24

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 = 60 Rev. 20
2	External Relief Dia	5.5 H/C	20.8 Side (3-3)		Inner			
3	External Relief Depth		2.5 H/C		20 H/C			
4	Inspection Done Before Hardening By (Name)				Rasi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		17	4	24			

Inspected By (Sign) & Date

Rasi 17/4/24

Reviewed by (Engineer-CNC)

Manager-QA