



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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11882/	40/60
2	Machined By		V. T. G. M/c Shop	Drg. No. 534
3	Pallet Die No.		13278(4.0) H/H	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/H Step 00, 798 H/H	Tapper, 4°
6	Inside Diameter	Drg. No.	660.12 H/H	Side length. 33.5
7	Width of Pellet Die	Drg. No.	324 H/H	Under cut. 9 H/H
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/H / 21.5 x 8 x 10 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping H/L of Holes. 12 Both Side
12	Tapping PCD		725 H/H	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 31 H/H	Tapping Depth. 32.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/5/24	2 Slot 32.1 H/H width 8 H/H Dash Both Side
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-Sink 1100247
2	External Relief Dia	4.5 H/H	outside (3-3)	Inner
3	External Relief Depth		24 H/H	20 H/H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		7 5 24	
Inspected By (Sign) & Date			Ravi 7/5/24	

Reviewed by (Engineer-CNC)

Manager-QA