



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.			
2	Machined By		11870	40/60
3	Pallet Die No.		V.T.C. H/c Shop	Dy. No. 130.584
4	Die Category	Drg. No.	13305 (6.0) H/c	Row 20
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	780 H/c Step OD, 798 H/c	Tabber 4°
7	Width of Pellet Die	Drg. No.	660.12 H/c	Step length 35.5
8	Grooves as per Drawing	Drg. No.	324 H/c	Under cut 9 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10 H/c 21.5 x 8 x 10 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		785 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H20, Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 31 H/c	Tapping Depth 35-38 H/c
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 14/5/24

1	As per programme no.			2 Slot 32.1 H/c Width 8 H/c Deep Both Side
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 Row = 34
2	External Relief Dia	6.5 H/c	Outside (3-3)	Inner			
3	External Relief Depth		26 H/c	20 H/c			
4	Inspection Done Before Hardening By (Name)		✓ Ravi ✓				
5	Material Sent For Hardening By (Name)		Lark Purvace				
6	Material Sent For Hardening On Date		14	15	24		
Inspected By (Sign) & Date			Ravi 14/5/24				

Reviewed by (Engineer-CNC)

Manager-QA