



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.		11313	36/55
2	Machined By		V. T. L. n/c Shop	Drg No. 1-8-0, 453
3	Pallet Die No.		11522 (4.0) n/c	Proc. as
4	Die Category	Drg. No.	J&K	
5	Out Side Diameter	Drg. No.	740 n/c	
6	Inside Diameter	Drg. No.	740 n/c, Step CD = 743.5 n/c	Tapper = 1°
7	Width of Pellet Die	Drg. No.	630.12 n/c	Step length = 28 n/c
8	Grooves as per Drawing	Drg. No.	290 n/c	Undercut = 1.7 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	15 x 8 x 5 n/c 15 x 8 x 5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes = 16 Q side
13	Tapping Hole Diameter		685 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c - Check by H2 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Rebk. 20.8 n/c	Tapping Rebk. 18.8 n/c
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 15/5/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
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 = 6°
2	External Relief Dia	4.5 n/c	outside (3-3)					low = 43
3	External Relief Depth		23 n/c			inner	19 n/c	
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forncore
6	Material Sent For Hardening On Date				15	5	24	

Inspected By (Sign) & Date

Ravi 15/5/24

Ravi 15/5/24

Reviewed by (Engineer-CNC)

Manager-QA