



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		10036	50/55
3	Pallet Die No.		V.T.L. M/C Shop	Dr. No. 1-20-639
4	Die Category	Drg. No.	12507 (8.0) H.H.	Reo-00
5	Out Side Diameter	Drg. No.	2+brwside	
6	Inside Diameter	Drg. No.	630 H.H. ✓ Step 002 624 H.H.	Tappers = 12°
7	Width of Pellet Die	Drg. No.	520.14 H.H. @	Step length = 18 H.H.
8	Grooves as per Drawing	Drg. No.	222 H.H. ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H.H. 13x8x5 H.H.	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565 H.H. ✓	Tapping No. of Holes = 12 Both Side
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 = 20.4 H.H.	Tapping Depth = 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 10/6/24

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

Counter = 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	8.5 H.H. Outside (3-3)		Inner						
3	External Relief Depth	13 H.H.		5 H.H.						
4	Inspection Done Before Hardening By (Name)		Raw							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		10	6	24					

Inspected By (Sign) & Date

Raw: 10/6/24

Reviewed by (Engineer-CNC)
10/6/24

Manager-QA