

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		12276	50/50
3	Pallet Die No.		V.T.L M/C Shop	Drg No. 1202 415
4	Die Category	Drg. No.	12301 (6.0) mm	Revised
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5.20 mm Step 00 = 4.99 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	4.20 ± 0.1 mm	Step length 1.5 mm
8	Grooves as per Drawing	Drg. No.	1.58 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	1.2 x 8 x 3 mm / 1.2 x 8 x 3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	Tapping no. of holes 8 Both side
13	Tapping Hole Diameter		4.54 mm	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Ball ok	
15	Tapping Hole Depth		Drill Depth 18.3 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/7/24

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 2.60 low = 15
2	External Relief Dia	6.5 mm	outside 2.2	inner				
3	External Relief Depth		4 mm	Mill				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		8	7	24			

Inspected By (Sign) & Date

Ravi 8/7/24

Reviewed by (Engineer-CNC)

Manager-QA