



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	Speciflcation	Observations	Remarks
1	Work Order No.		12617	27/40
2	Machined By		V. T. L. H/c Shop	Dy. Insp. E. G. 15062
3	Pallet Die No.		12349 (3.0) H/c	Rev. 100
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step 0.2 = 498.88
6	Inside Diameter	Drg. No.	420.12 mm	Step long the 18 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	12x8x3 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Hole. 8
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		Max = Check by Max Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.4 mm	Tapping Depth 16.
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/8/24

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
Rev 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 mm	outside (2-2)		inner		
3	External Relief Depth		16 mm		13 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		22	8	24		

Inspected By (Sign) & Date

Ravi 22/8/24

22/8/24

Reviewed by (Engineer-CNC)

Manager-QA