



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.		12623	38/45
2	Machined By		V. T.L. n/c Shop	Drg No. 1.2.02 5430
3	Pallet Die No.		12821 (3.0)mm	Rev 2 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610mm Step 002 612mm	Step length 20mm
6	Inside Diameter	Drg. No.	520.14mm	Under cut = 1mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping of Holes 10-18.5 Both Side
12	Tapping PCD		565mm	
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 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/24

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

1	Counter Sinking Depth & Finish	OK					Counter 60° Row = 38
2	External Relief Dia	3.5mm	Outside (3.3)	Inner			
3	External Relief Depth		13mm	7mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		23	8	24		

Inspected By (Sign) & Date

Ravi 23/8/24

Reviewed by (Engineer-CNC)

Manager-QA