



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.		10085	
2	Machined By		V.T.L. H/c. Shop	34/50
3	Pallet Die No.		9646 (3.0) MM	Dry No. 1.8.0.12301
4	Die Category	Drg. No.	M. Jumbo	Renewal
5	Out Side Diameter	Drg. No.	700 MM	
6	Inside Diameter	Drg. No.	Step OD. 693 MM	Step length 20 MM
7	Width of Pellet Die	Drg. No.	600.12 MM	
8	Grooves as per Drawing	Drg. No.	222 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 MM 12x8x7 MM	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c. Shop	Tapping No. of Holes, 12 Both Side
13	Tapping Hole Diameter		640 MM	
14	Tapping On Second Side	Half pitch of 1st side	M202 Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 MM	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 10/8/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		OK No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner		Ravi 23
3	External Relief Depth		22 MM		16 MM		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date			10	8	23	
							Ravi 10/8/23

Inspected By (Sign) & Date

Ravi 10/8/23

Reviewed by (Engineer-CNC)

Manager-QA