



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.		12884 ✓	
2	Machined By		V.T.L M/c Shop	33/45 ✓
3	Pallet Die No.		13033 (4.0) mm	Dry No. 1.8 id 1147
4	Die Category	Drg. No.	Sew ✓	Rew. (00) ✓
5	Out Side Diameter	Drg. No.	510 mm	
6	Inside Diameter	Drg. No.	Step OD 499 mm	Tapper 12° ✓
7	Width of Pellet Die	Drg. No.	420.12 mm	Step length 20 mm ✓
8	Grooves as per Drawing	Drg. No.	182 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Hold / 8 Both Side
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		M.20 Check by M.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping depth 16.5 mm ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/09/24

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	outside	Counter - 60°
2	External Relief Dia	4.5 mm	(2-2)	Row 25
3	External Relief Depth	17 mm	Tuner 18 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnes	
6	Material Sent For Hardening On Date	24	09	24

Inspected By (Sign) & Date

Ravi 24/09/24

Reviewed by (Engineer-CNC)

Manager-QA