



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.		12886 ✓	45/50 ✓
2	Machined By		V.T.L M/c Shop	Dry No. L.S.d 406
3	Pallet Die No.		13097 (3.2) mm	Row (00) ✓
4	Die Category	Drg. No.	SSEW ✓	
5	Out Side Diameter	Drg. No.	620 mm Step d	Step 23.9 mm Tapper 12°
6	Inside Diameter	Drg. No.	520.12 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	222 mm	Under cut - 1.9 mm
8	Grooves as per Drawing	Drg. No.	13X8X5 mm / 13X8X5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes / 12 Both Side
12	Tapping PCD		565 mm ✓	
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 20.4 mm	Tapping Dept 18.5 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 - Go
2	External Relief Dia	3.8 mm	(3-3)						Row 37
3	External Relief Depth		12 mm						5 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