



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.		12910	30/40
2	Machined By		V.T.L M/c Shop	Dy. No. 18.D. 154
3	Pallet Die No.		12348 (4.0) mm	Reason
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	398 mm Step OD = 384 mm	Step length 1.5
6	Inside Diameter	Drg. No.	318.12 mm / 315.12 mm (A)	
7	Width of Pellet Die	Drg. No.	134 mm	
8	Grooves as per Drawing	Drg. No.	8 x 5 x 3 mm / 8 x 5 x 3 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: 8 Both Side
12	Tapping PCD		349 mm	
13	Tapping Hole Diameter		1/2" 2 Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 16.4 mm Tapping Depth = 14.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi . 30/09/24	
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° Row - 18
2	External Relief Dia	4.5 mm	(2-2)	Inner
3	External Relief Depth		12 mm	8 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		30 09 24	
Inspected By (Sign) & Date			Ravi . 30/9/24	

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30/9/24

Reviewed by (Engineer-CNC)

Manager-QA