



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.		12974	22/40
2	Machined By		V.T.L. M/C Shop	Drg No. 1.8.D.115A
3	Pallet Die No.		12530 (2.8) M/C	Rev 2.0
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	394.9 M/C	Step OD = 382.9 M/C
6	Inside Diameter	Drg. No.	315.12 M/C	Step length 9.5
7	Width of Pellet Die	Drg. No.	126 M/C	
8	Grooves as per Drawing	Drg. No.	126x3 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	126x3 M/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		350 M/C	Tapping No of Holes - 8 Both Side
13	Tapping Hole Diameter		5/8" = Check by 5/8" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 M/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 9/10/24

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°
2	External Relief Dia	3.3 M/C	Outside 2.2	Inner				low = 20
3	External Relief Depth		20 M/C	18 M/C				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Formac
6	Material Sent For Hardening On Date		9	10	24			

Inspected By (Sign) & Date Ravi 9/10/24

Reviewed by (Engineer-CNC) Satyam 9/10/24

Manager-QA