



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.			
2	Machined By		13020	22/70
3	Pallet Die No.		V.T.L. n/c Shop	Dr. No. 13.02.383
4	Die Category	Drg. No.	12069 (6.0) n/c	2002 n/c
5	Out Side Diameter	Drg. No.	33310	
6	Inside Diameter	Drg. No.	660 n/c Step OD: 623 n/c	Tapper: 12°
7	Width of Pellet Die	Drg. No.	520.12 n/c	Step length: 18 n/c
8	Grooves as per Drawing	Drg. No.	186 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x7 n/c 10x10x7 n/c	Face Side
10	Drilling Area Surface Smoothness		ok	Step 1 n/c Deep
11	Tapping Operator		n/c Shop	at Both Side
12	Tapping PCD		565 n/c	Tapping No. of Holes: 12
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 n/c	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/10/24	
1	As per programme no.			2 slot
2	Gun Drilling Work Completed On			25.1 n/c width
3	Hole Finish In Gun Drilling	Marked	ok	6 n/c Deep
4	Defective Holes (If Any)		No	Both Side
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	7.0 n/c	All Rows	Rows: 19
3	External Relief Depth		48 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For race	
6	Material Sent For Hardening On Date		22 10 24	
Inspected By (Sign) & Date			Ravi 22/10/24	

Reviewed by (Engineer-CNC)

Manager-QA