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.		13055	38/39
2	Machined By		V.T.L. M/c Shop	Drg No. 130, 100 Rev 00
3	Pallet Die No.		13264 (3.0) MM	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	598 MM Step OD. 612 MM	Step length. 8 MM Undercut. 7 MM
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	288 MM	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 MM / 13 x 8 x 5 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. 18 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M20 x 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 Depth. 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rao: 19/10/24	
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° Rows 38
2	External Relief Dia	3.3 MM		All Rows				
3	External Relief Depth			7 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		19	10	24			
	Inspected By (Sign) & Date		Rao: 19/10/24					

Satya 19/10/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner