



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.		13156	48/55
2	Machined By		V.T.L. N/C Shop	Dy No. 18.0.539
3	Pallet Die No.		13607 (4.0) mm	Rev 2.00
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630mm Step OD - 624mm	Step length 90mm
6	Inside Diameter	Drg. No.	520.12 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x3mm / 13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565mm	Tapping No. of holes, 12 Both Side
13	Tapping Hole Diameter		M20, Check by M20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/11/24

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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5mm	Outside (2-3)		Inner					
3	External Relief Depth		15mm		7mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Romace					
6	Material Sent For Hardening On Date		4	11	24					

Inspected By (Sign) & Date

Ravi 4/11/24

Reviewed by (Engineer-CNC)

Manager-QA