



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8613

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13374 ✓	50/50
2	Machined By		V. T. L. H/c Shop	Dy. No. 8152
3	Pallet Die No.		11876(4.0) ✓	8370
4	Die Category	Drg. No.	58870 ✓	
5	Out Side Diameter	Drg. No.	62mm / Step OD = 612mm	Step length = 19.5
6	Inside Diameter	Drg. No.	42.0 ± 0.12 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 mm	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		M20 = Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm Tapping Depth = 18.9 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/24

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
Low = 25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 mm	90 Side (3-3)	Inner			
3	External Relief Depth		5 mm	Mill			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		25	11	24		

Inspected By (Sign) & Date

Ravi 25/11/24

Saty 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA