



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

8709

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13134	20/20
3	Pallet Die No.		V.T.L. n/c Shop	Dig. No. 130-978
4	Die Category	Dr. No.	13815(3.0) mm	20/20
5	Out Side Diameter	Dr. No.	Jumbo	
6	Inside Diameter	Dr. No.	79.0 mm / 79.4 mm / 743.4 mm	Tapping 10°
7	Width of Pellet Die	Dr. No.	630.0 mm / 630.14 mm	Step length 33 mm
8	Grooves as per Drawing	Dr. No.	265 mm	
9	Fitting Sizes on CNC Plate	Dr. No.	15x8x5 mm / 15x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping H. of Hole 15 Pete Side
13	Tapping Hole Diameter		685 mm	
14	Tapping On Second Side	Half pitch of 1st side	M202 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 mm	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date Ravi 5/12/24

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 - 4 Hole Closed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Corner Boring Depth & Finish	ok						
2	External Relief Dia							No - relief
3	External Relief Depth							
4	Inspection Corner Bore Inspecting By (Name)							Ravi
5	Mastered Start For Inspecting By (Name)							Ko. Ph. ab. k. p. r. v. e. c. e.
6	Mastered Start For Inspecting On Dates							6 12 201

Inspected By (Sign) & Date Ravi 06/12/24

Inspected by (Signature) (CNC)

Manager QA