



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.		13477	45/50
2	Machined By		V.T.L. N/C Shop	Digital Micrometer
3	Pallet Die No.		13009 (6.0) mm	Recess
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20 mm, Step 00 = Tapper 12°	
6	Inside Diameter	Drg. No.	5.20 ± 0.12 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 mm	
8	Grooves as per Drawing	Drg. No.	1348 x 5 mm 1348 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes, 12 Both Side
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20 - 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 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/12/24	
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	
Note : Mark the defective holes/ Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter G: Ravi 23
2	External Relief Dia	6.5 mm	Outside (3-3)	Inner
3	External Relief Depth		11 mm	5 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		9	12 24
Inspected By (Sign) & Date			Ravi 9/12/24	

Reviewed by (Engineer-CNC)

Manager-QA