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.		13545	40/40
2	Machined By		V.T.L M/C Shop	Dy No. 1.8.D.1028
3	Pallet Die No.		13885 (6.0) MM	Rev 2
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	398 MM / Step OD = 383 MM	Step length 10.5
6	Inside Diameter	Drg. No.	ID 318.12 MM / ID 315.12 MM (Bore = 318.12 MM)	
7	Width of Pellet Die	Drg. No.	108 MM	Maintained After Hard in Fitting Side
8	Grooves as per Drawing	Drg. No.	4x5x3 MM / 4x5x3 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 & Both Side
12	Tapping PCD		350 MM	
13	Tapping Hole Diameter		0 1/2" Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 12.4 MM Tapping Depth 10.5 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 12/12/24	
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 60° Rev 11
2	External Relief Dia	6.5 MM	outside (2→2)		Inner			
3	External Relief Depth		6 MM		Nill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		12	12	24			
	Inspected By (Sign) & Date		Ravi 12/12/24					

Satya 13/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner