



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13571 ✓	34/40
2	Machined By		V.T.L n/c Shop	Drg No. 1.2.0.15.062
3	Pallet Die No.		11820(2.2) ✓	Rev - 00
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	500 mm Step OD = 498.83 mm ✓	Tapping 12°
6	Inside Diameter	Drg. No.	420.12 mm ✓	Step length 13 mm ✓
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	1248 x 3 mm 1248 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm ✓	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	Tapping No. of Holes: 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 mm Tapping Depth 16.6 mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/24

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 - 2 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok								Counter 60
2	External Relief Dia	3.3 mm	outside 2.2		Inner					Low 28
3	External Relief Depth		12 mm		6 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			13	12	24				

Inspected By (Sign) & Date

Ravi 13/12/24

Reviewed by (Engineer-CNC)

Manager-QA