



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.		13561/	33/50/
2	Machined By		V.T.L. H/c Shop	Dy. No. L-8-C-98
3	Pallet Die No.		13479(3.0) H	Rev 2.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	62 mm, Step 0.0, Tapper. 12°	
6	Inside Diameter	Drg. No.	52.12 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 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		M/c Shop	Tapping No. of holes 12 Roh 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 20.3 mm Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/12/24

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

Count 002 60/

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 mm	outside (3-3)		Inner				
3	External Relief Depth		18 mm		12 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		16	12	24				

Inspected By (Sign) & Date

Ravi 16/12/24

Satyam 16/12/24

Reviewed by (Engineer-CNC)

Manager-QA