



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.		13591	44/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 1-2-C2980
3	Pallet Die No.		13648(4.0) n/c	Rev: 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	6.20 n/c, Step 002, Tapper = 12°	
6	Inside Diameter	Drg. No.	5.20 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	2.22 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
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 n/c	
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 n/c, Tapping Depth 18.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/12/24

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: 31
2	External Relief Dia	4.3 n/c	Outside (3-3)		Inner			
3	External Relief Depth		14 n/c		6 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		18	12	24			

Inspected By (Sign) & Date

Ravi 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA