



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.		13627	44/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1.2.02.18
3	Pallet Die No.		13651(4.0)H	200200
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	6.2mm Step 00. Tapers 12°	
6	Inside Diameter	Drg. No.	5.20.12 H	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 H	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 2-12 Both Side
12	Tapping PCD		56.5 H	
13	Tapping Hole Diameter		M20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3mm Tapping Depth 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/12/24

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°
2	External Relief Dia	4.3mm	outside (3-3)					Rows 31
3	External Relief Depth		14mm					
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	12	24			

Inspected By (Sign) & Date

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA