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.		13666	40/40
2	Machined By		V.T.L M/C Shop	Drg No. 1x8C215062
3	Pallet Die No.		12717 (5.0) MM	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM, Step OD = 498.88 MM	Tapper = 12°
6	Inside Diameter	Drg. No.	420.12 MM	Step length = 18 MM
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12x8x3 MM | 12x8x3 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, 8 Both Side
12	Tapping PCD		454 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 = 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 21/12/24	
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° Row = 17
2	External Relief Dia	5.3 MM	Outside (2.2)		Inner			
3	External Relief Depth		4 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		21	12	24			
	Inspected By (Sign) & Date		Ravi 21/12/24					

Satya 21/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner