



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.		13527	48/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.02781
3	Pallet Die No.		13452(6.0)mm	Re. 01.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm, Step OD = 49.83mm	
6	Inside Diameter	Drg. No.	42.12mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	158mm	Step length 18mm
8	Grooves as per Drawing	Drg. No.	12x8x3mm 12x8x3mm	
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 2 Beta Side
12	Tapping PCD		454mm	
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 18.3mm Tapping Depth 16.6	
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

Counter = 6°
Re. 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5mm	outside (2-2)		Innen		
3	External Relief Depth		8mm		2mm		
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

[Signature]
18/12/24

Reviewed by (Engineer-CNC)

Manager-QA