



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)

9003

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13952	48/55
2	Machined By		M.T.L. n/c. Stop	Digital U.O. 539
3	Pallet Die No.		13601 (4.0) mm	
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	629.8 mm / Step OD 62 mm	Tappers 12
6	Inside Diameter	Drg. No.	520.12 mm	Step length 9 mm
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13487 3 mm / 13487 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Stop	Tapping No of Holes: 12 Bolt Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M200 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm / Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 15/1/25

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 Bo:

1	Counter Sinking Depth & Finish	ok								Ravi: 25
2	External Relief Dia	4.5 mm	outside (3-3)		Inner					
3	External Relief Depth		15 mm		7 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			15					25	

Inspected By (Sign) & Date

Ravi: 15/1/25

Reviewed by (Engineer-CNC)
Satyam
15/1/25

Manager-QA