



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.		13020	82/70
2	Machined By		V.T.L. H/C Shop	Drg No. 1.2.9.282
3	Pallet Die No.		12994 (6.0) H	Rev: 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	660 H	Step 00, 682 H
6	Inside Diameter	Drg. No.	520.12 H	Tappet. 12
7	Width of Pellet Die	Drg. No.	186 H	Step length. 18 H
8	Grooves as per Drawing	Drg. No.	10x10x7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x7 H	
10	Drilling Area Surface Smoothness		ok	Face Side Step 1mm Deep Both Side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H	Tapping Hole Holes. 12 Both Side
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H	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 Slot 25.1 H width 8 H Deep Both Side
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 = 6° Row = 19
2	External Relief Dia	7.0 H	All Rows	
3	External Relief Depth		48 H	
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	1 25
Inspected By (Sign) & Date			Ravi 15/1/25	

Reviewed by (Engineer-CNC)

Manager-QA