



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)

6007

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10150	33/47
2	Machined By		V.T.L n/c Shop	Digital I.S.O-875
3	Pallet Die No.		10793 (2.8)mm	Rev=00
4	Die Category	Drg. No.	2-1/2 outside	
5	Out Side Diameter	Drg. No.	614mm Step OD 622.2mm	Tapper=12
6	Inside Diameter	Drg. No.	520.12mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	222mm	Undercut 4.1mm
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		n/c Shop	Tapping No. of holes: 12 Both side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		M20 - Check by HSS Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pass: 28/8/23

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							Pass 40
2	External Relief Dia	3.3mm	outside (3-3)		inner				
3	External Relief Depth		20mm		14mm				
4	Inspection Done Before Hardening By (Name)								Pass
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			28	8	23			

Inspected By (Sign) & Date

Pass: 28/8/23

Reviewed by (Engineer-CNC)

Manager-QA