



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9346	120/120
2	Machined By		V.T.L. N/C Shop	Drill No. 6.9.0-559
3	Pallet Die No.		10465 (3.0) MM	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 MM Step OD: 743.5 MM	Tapper = 10°
6	Inside Diameter	Drg. No.	630.13 MM	Step length = 23 MM
7	Width of Pellet Die	Drg. No.	265 MM	
8	Grooves as per Drawing	Drg. No.	15x8x5 MM / 15x8x5 MM	
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 = 16 Both Side
12	Tapping PCD		685 MM	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 MM Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/6/23

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								Ravi 46
2	External Relief Dia	—	—	NO	—	Relief				
3	External Relief Depth									
4	Inspection Done Before Hardening By (Name)					Ravi				
5	Material Sent For Hardening By (Name)					Keshav				
6	Material Sent For Hardening On Date				17	6	23			

Inspected By (Sign) & Date

Ravi 17/6/23

Reviewed by (Engineer-CNC)

Manager-QA