



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6040

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.		10200	28/50
2	Machined By		V.T.L. H/c Shop	Dy No 12.02.11286
3	Pallet Die No.		9073 (2.8)mm	Passes
4	Die Category	Drg. No.	33370	
5	Out Side Diameter	Drg. No.	620mm Step OD = 624mm	Tappers 12°
6	Inside Diameter	Drg. No.	52.12mm ✓	Step length 18mm
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	13x8x3mm 13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M2x2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 13.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 9/9/23	
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 - 1 Hole Closed (0)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Done 31
2	External Relief Dia	33mm	Outside (3-3)	Inner
3	External Relief Depth		25mm	22mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9	9 23
Inspected By (Sign) & Date			Ravi 9/9/23	

Reviewed by (Engineer-CNC)

Manager-QA