

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.		15189	45/6-
2	Machined By		V.T.L. H/O Shop	Dy H-12-0.1343
3	Pallet Die No.		15758(8.0)H	Rev 1.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	78mm Step on 798mm	Tapper. 40
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.4
7	Width of Pellet Die	Drg. No.	323.7mm	Under cut 29mm
8	Grooves as per Drawing	Drg. No.	21.5x8x7mm / 21.5x8x7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping
12	Tapping PCD		725mm	2 holes - 18
13	Tapping Hole Diameter		120mm Check by 120R-12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 36.4mm	Tapping Depth 38.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.			28/6/25	2 St 10
2	Gun Drilling Work Completed On				32.1mm inside
3	Hole Finish In Gun Drilling	Marked	OK		8mm Deep
4	Defective Holes (If Any)		No		Both Side

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter 60
2	External Relief Dia	8.5mm	Opp side (3-3)		Inner			Rev - 28
3	External Relief Depth		23mm		15mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date			26	6	25		
Inspected By (Sign) & Date								

Reviewed by (Engineer-CNC)

Manager-QA