



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.		10444	20/45
2	Machined By		V.T.L. n/c Shop	Dy. No. 18.02.644
3	Pallet Die No.		10843 (2.0) n/c	Rev: 00
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	61.0 n/c Step 6.02 621.5 n/c	Tap per 12°
6	Inside Diameter	Drg. No.	52.012 n/c	Step length 21.5
7	Width of Pellet Die	Drg. No.	22.2 n/c	Under cut 5.75
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	Tapping No. of Holes: 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 17/10/23

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: 38
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner					
3	External Relief Depth		18 n/c		15 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			17	10	23				

Inspected By (Sign) & Date

Ravi: 17/10/23

Reviewed by (Engineer-CNC)
Sohy 17/10/23

Manager-QA