



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.		10448 ✓	33/50
2	Machined By		V.T.L. N/C Shop	Drill No. L2C210178
3	Pallet Die No.		8822 (3.0) ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	MJEW	
5	Out Side Diameter	Drg. No.	700 MM / Step OD 702 MM	Step length = 24 MM
6	Inside Diameter	Drg. No.	600.12 MM	Tapper = 12°
7	Width of Pellet Die	Drg. No.	265 MM	Under cut = 2 MM
8	Grooves as per Drawing	Drg. No.	15x8x7 MM / 15x8x7 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		64 MM	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 MM	Tapping Depth 18.2
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 (A)
4	Defective Holes (If Any)		No - 2 Hole Closed

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

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 MM	outside (3-3)		inner		
3	External Relief Depth	/	23 MM		17 MM		
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)

Manager-QA