



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.		10384	36/50
2	Machined By		V.T.L n/c Shop	Drg No. = L.E.C = 9980
3	Pallet Die No.		10809 (2.0) mm	Rev 2.00
4	Die Category	Drg. No.	2 extrawide	
5	Out Side Diameter	Drg. No.	620mm, Step OD = Tapper = 12° Step length = 18mm	
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 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 = 12 Both side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		N2 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm Tapping Depth = 18.3	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/10/23

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							Rev. 38
2	External Relief Dia	3.5 mm	outside (3-3)		Inner				
3	External Relief Depth		20 mm		14 mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Purchase
6	Material Sent For Hardening On Date		13	10	23				

Inspected By (Sign) & Date

Ravi 13/10/23

Reviewed by (Engineer-CNC)

Manager-QA