

 Lark Engineering Company (India) Pvt. Ltd. I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)				Form No.	10795 CNC/QA/FM/02
Inprocess Inspection (Pellet Dies)				Rev. No.	01
				Rev. Date	31-07-2013
S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.		16117	38/45	
2	Machined By		V.T.L M/c Shop	Dry No-16115030	
3	Pallet Die No.		14188 (3.0)mm	(Rev 00)	
4	Die Category	Drg. No.	SSCW		
5	Out Side Diameter	Drg. No.	610 mm	Step OD - 611.9 mm	
6	Inside Diameter	Drg. No.	520.14 mm	Step length = 20 mm	
7	Width of Pellet Die	Drg. No.	222 mm	Under cut 1 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 / 13x8x5 mm		
9	Fitting Sizes on CNC Plate	Drg. No.	OK		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		M/c Shop	Tapping No	
12	Tapping PCD		565 mm	of Holes - 12	
13	Tapping Hole Diameter		M.20 check by M.20 Bolt	Both Side	
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth = 18.4 mm	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi	03/10/23	
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		Counter - 60	
2	External Relief Dia	3.5 mm	Outside (3-3)	Inner	Raw - 38
3	External Relief Depth		13 mm	7 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		03	10	25
Inspected By (Sign) & Date			Ravi	01/10/23	

Reviewed by (Engineer-CNC)

Manager-QA