



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.		16050	40/50
2	Machined By		V.T.I. M/c Shop	Dry No. 1-42/11286
3	Pallet Die No.		14436 (4.0) mm	Rev. 02
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	62.1 mm	Step oD = 62.9 mm, Tapped = 12
6	Inside Diameter	Drg. No.	52.14 mm	Step length = 28 mm
7	Width of Pellet Die	Drg. No.	186 mm	Undercut = 1.9 mm
8	Grooves as per Drawing	Drg. No.	13x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of Holes = 12
12	Tapping PCD		56.5 mm	Both Side
13	Tapping Hole Diameter		M2x Check by M2 Bolt	
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

1	As per programme no.		Ravi	15/10/25
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 30°
2	External Relief Dia	4.5 mm	Outside 2-3		Inside 10 mm			Row 225
3	External Relief Depth		14 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			15	10	25		

Inspected By (Sign) & Date

			Ravi	15/10/25
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Reviewed by (Engineer-CNC)

Manager-QA