



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)

6313

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10556	34/47
2	Machined By		V.T.L. N/c Shop	Dry Nos 6827/202
3	Pallet Die No.		10847 (3.2) N/c	Rev 2.01
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	814 N/c	Step 002 622.5mm Top part 12
6	Inside Diameter	Drg. No.	520.12 N/c	Step length 18mm
7	Width of Pellet Die	Drg. No.	222 N/c	Under cut 4.2mm 14.7mm
8	Grooves as per Drawing	Drg. No.	13x8x5 N/c 13x8x5mm	
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		565mm	
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 20.4mm	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sanjeev 24/10/23

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				
2	External Relief Dia	3.8mm	Outside (3-3)	Innen		
3	External Relief Depth		17mm	13mm		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		24	10	23	

Inspected By (Sign) & Date

Sanjeev 24/10/23

Reviewed by (Engineer-CNC) 25/10/23

Manager-QA