



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.		9947	60/60
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.0.584
3	Pallet Die No.		11039 (10.0) H	Rev=01
4	Die Category	Drg. No.	7umbs	
5	Out Side Diameter	Drg. No.	78mm / Step 00, 797.8mm	Tappers 4"
6	Inside Diameter	Drg. No.	66.12mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut 8.9
8	Grooves as per Drawing	Drg. No.	21.5x8x10mm / 21.5x8x10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 19 Both Side
12	Tapping PCD		785mm	
13	Tapping Hole Diameter		M20 Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.4mm Tapping Depth 28.2	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/10/23

1	As per programme no.		—————	2 SLOT 32.1mm width 8mm Deep Both Side
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=19
2	External Relief Dia	—————	—————	No	Relief	—————		
3	External Relief Depth	—————	—————	—————	—————	—————		
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Keshav			
6	Material Sent For Hardening On Date		23	10	23			

Inspected By (Sign) & Date

Ravi 23/10/23

Reviewed by (Engineer-CNC)

Manager-QA