



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.		10459	27/47
2	Machined By		V.T.C. H/C Shop	Drg No. 1.2.C.2.897
3	Pallet Die No.		10845 (3.0) H	Rev 2.0
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	Ø14 H, Step OD = 6Ø1.5 H	Tapper = 12°
6	Inside Diameter	Drg. No.	5Ø0.12 H	Step length = 9.5
7	Width of Pellet Die	Drg. No.	222 H	Under cut = 3.75
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.5 H	Tapping Depth = 13.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 21/11/23

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 - 2 Hole Closed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	Ø3.5 H	outside (3-3)		inner				
3	External Relief Depth		23 H		20 H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark furnace
6	Material Sent For Hardening On Date		21	11	23				

Inspected By (Sign) & Date Ravi 21/11/23

Reviewed by (Engineer-CNC) [Signature]

Manager-QA