



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)

6430

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10683	40/50
3	Pallet Die No.		N.T.L. n/c Shop	Dry die look 8550
4	Die Category	Drg. No.	11076 (4.0) n/c	
5	Out Side Diameter	Drg. No.	outside	
6	Inside Diameter	Drg. No.	Ø 20 n/c, Step 00, 612 n/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.12 n/c	
8	Grooves as per Drawing	Drg. No.	332 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		565 n/c	Tapping No. of holes 12 Both Sides
14	Tapping On Second Side	Half pitch of 1st side	n/c - Check by H2 Bolt	
15	Tapping Hole Depth		ok	Tapping Depth 8.8
16	Perpendicularity of Tapped Hole		Drill Depth 20 n/c	
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 17/11/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		ok

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

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	4.5 n/c	outside (2-3)	inner		
3	External Relief Depth		14 n/c	10 n/c		
4	Inspection Done Before Hardening By (Name)					
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date					

Inspected By (Sign) & Date

17 11 23
Ravi 17/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Material Sent For Hardening By (Name)			
Material Sent For Hardening On Date	18	11	23