



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.		10679	40/100
2	Machined By		V.T.L. M/c Shop	Drg No. F-SCC/15002
3	Pallet Die No.		10715 (5.0) M/M	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 M/M Step OD, Tapper	12° Step length 18 M/M
6	Inside Diameter	Drg. No.	420.14 M/M	Step length 18 M/M
7	Width of Pellet Die	Drg. No.	157.5 M/M	
8	Grooves as per Drawing	Drg. No.	12x8x3 M/M / 11.5x8x3 M/M	
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 B Both Side
12	Tapping PCD		454 M/M	
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 18.4 M/M Tapping Depth 16 M/M	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/11/23

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

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

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	5.3 M/M	Outside (2-2)		Inner					
3	External Relief Depth		5 M/M		Mill					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		23	11	23					

Inspected By (Sign) & Date

Ravi 23/11/23

Reviewed by (Engineer-CNC)

Manager-QA