



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

9269

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9869	40/47
2	Machined By		V.T.L. N/C Shop	Dy No. 1-8015431
3	Pallet Die No.		9997 (3.0)mm	Rev 2.00
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	614mm, Step 00, 612mm	Step length 19.5mm
6	Inside Diameter	Drg. No.	58.42mm	
7	Width of Pellet Die	Drg. No.	98.8mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm, 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		56.5mm	
13	Tapping Hole Diameter		M20x 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 18.8mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/7/23

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							Rev = 28
2	External Relief Dia	3.5mm	Outside (3-3)		Inner				
3	External Relief Depth		13mm		7mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			7		7		23	

Inspected By (Sign) & Date

Ravi 27/7/23

Reviewed by (Engineer-CNC)

Manager-QA