



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.		10918	38/50
2	Machined By		V. T. L. H/c Shop	Drg No. 1.8.09980
3	Pallet Die No.		11263 (3.0) H4	Rev 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 H4 Step O.D. Taper = 12°	
6	Inside Diameter	Drg. No.	520.12 H4	Step length = 12.5
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
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		565 H4	
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 = 20.4 H4 Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/1/24

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						Counter 60°
2	External Relief Dia	3.5 H4	outside (2.2-2)		Inner			
3	External Relief Depth		18 H4		12 H4			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lanku Porrace
6	Material Sent For Hardening On Date			11	1	24		

Inspected By (Sign) & Date Ravi 11/1/24

Reviewed by (Engineer-CNC) [Signature] 11/1/24

Manager-QA