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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.		11054	42/50
2	Machined By		V.T.L. N/A Shop	Drg No. 13.02 71
3	Pallet Die No.		11447 (4.0) mm	Rev. 00
4	Die Category	Drg. No.	extra wide	
5	Out Side Diameter	Drg. No.	620 mm, Step OD: 622.3 mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.12 mm	Step length 17 mm
7	Width of Pellet Die	Drg. No.	222 mm	Under cut 1.25 mm
8	Grooves as per Drawing	Drg. No.	9x10x4 mm / 9x10x4 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.3 mm Tapping Depth: 19 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/11/24

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	4.3 mm	Outside (3.3)		Inner		Lower 22
3	External Relief Depth		12 mm		8 mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		22	1	24		

Inspected By (Sign) & Date

Ravi 22/11/24

Satyam 22/11/24

Reviewed by (Engineer-CNC)

Manager-QA