



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.		10994	35/50
2	Machined By		V.T.L. H/c Shop	Dy No. 13.02.403
3	Pallet Die No.		11713 (4.0) H/c	Rev. no
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm, Step OD: 49mm	Step length: 12.4
6	Inside Diameter	Drg. No.	42.02 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of Holes: 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 19.8 mm Tapping Depth: 17.2 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/1/24

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.5 mm	Outside (2-2)		Inner					
3	External Relief Depth		19 mm		15 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Kanneer
6	Material Sent For Hardening On Date			20	1	24				

Inspected By (Sign) & Date

Ravi 30/1/24

Reviewed by (Engineer-CNC)

Manager-QA