



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

6840

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11115	50/60
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.9.02-409
3	Pallet Die No.		10199(4.0) n/c	REV 00
4	Die Category	Drg. No.	588TD	
5	Out Side Diameter	Drg. No.	64.0 n/c	Step length = 19.4
6	Inside Diameter	Drg. No.	52.0 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x5 n/c 13x8x5 n/c (A)	
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 n/c	
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 = 21.3 n/c	Tapping Depth = 19 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/1/24

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°
R10 = 25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c	60 side (2-3)	Inner			
3	External Relief Depth		18 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Ravnare				
6	Material Sent For Hardening On Date		28	1	24		
Inspected By (Sign) & Date		Ravi 22/1/24					

Reviewed by (Engineer-CNC)

Manager-QA

Reviewed by (Engineer-CNC)

Manager-QA