



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.		11258	40/47
2	Machined By		V. T. L. H/c Shop	Digitized by 1.80.15431
3	Pallet Die No.		9417 (3.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	614 H/c / Step OD = 612 H/c / Step length = 19.5	
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	229 H/c	
8	Grooves as per Drawing	Drg. No.	13x8 = 5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping dia of holes 12 Both side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H/c = Check by new Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 H/c / Tapping Depth = 19.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/2/24

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

Count as 60

1	Counter Sinking Depth & Finish	ok						Count as 28
2	External Relief Dia	3.5 H/c	outside (2-3)		Inner			
3	External Relief Depth		13 H/c		7 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Forcel			
6	Material Sent For Hardening On Date			1	2	24		

Inspected By (Sign) & Date

Ravi 11/2/24

Reviewed by (Engineer-CNC)

Manager-QA