



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.		11430	36/06
2	Machined By		V.T.L. M/C Shop	Dy. No. 1.3.0 = 8083
3	Pallet Die No.		11398(3.0) M/C	Rev. 2.01
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	612 M/C Step 002 693.5	Tap hole 12°
6	Inside Diameter	Drg. No.	590.12 M/C	Step length 18 M/C
7	Width of Pellet Die	Drg. No.	186 M/C	Under cut 25.8 M/C
8	Grooves as per Drawing	Drg. No.	14x8x5 M/C / 14x8x5 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		565 M/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 20.8 M/C Tapping Depth 18.8 M/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/3/24

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 M/C	outside (3-3)		Inner					Ravi 30
3	External Relief Depth		16 M/C		10 M/C					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			5	3	24				

Inspected By (Sign) & Date

Ravi 5/3/24

Reviewed by (Engineer-CNC)
S. S. 5/3/24

Manager-QA