



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11450	45/45
2	Machined By		V. T. L. n/c Shop	Dy. No. 1. S. D. 597
3	Pallet Die No.		11786 (4.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	610mm / Step 00 = 600.3mm	Tabber = 12°
6	Inside Diameter	Drg. No.	520.12mm	Step Length = 13mm
7	Width of Pellet Die	Drg. No.	222mm	Under cut = 6.15mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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		565mm	
13	Tapping Hole Diameter		M20 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8mm	Tapping Depth = 18.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/3/24

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	4.5mm	outside (3-3)	Inner			Row 31
3	External Relief Depth		7mm	Nil			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		9	3	24		

Inspected By (Sign) & Date

Ravi 9/3/24

Satyam 9/3/24

Reviewed by (Engineer-CNC)

Manager-QA