



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.		11433	210/50
2	Machined By		V. T. L N/A Shop	Dy. No. 1-8-CL 6178
3	Pallet Die No.		8897 (4.0) MM	Recess
4	Die Category	Drg. No.	HJ820	
5	Out Side Diameter	Drg. No.	700 MM, Step OD 2 708 MM	Step length 24
6	Inside Diameter	Drg. No.	600.12 MM	Tapper 12°
7	Width of Pellet Die	Drg. No.	265 MM	Undercuts 14°
8	Grooves as per Drawing	Drg. No.	15x8x7 MM 15x8x7 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		640 MM	
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 MM	Tapping Depth = 21.3 MM
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/3/24

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							
2	External Relief Dia	4.5 MM	Outside (3-35)		Inner				
3	External Relief Depth		14 MM		10 MM				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		2	3	24				

Inspected By (Sign) & Date

Ravi 21/3/24

Reviewed by (Engineer-CNC)
 Sathy 21/3/24

Manager-QA