



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.		11483/	150/150/
2	Machined By		V.T.L N/C Shop	Drg No. L.E.C. 7010
3	Pallet Die No.		12132 (4.0) H/H	Rev. 00/
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 H/H, Step OD. 743.4 H/H	Tapping 10/
6	Inside Diameter	Drg. No.	630.12 H/H	Step length 23 H/H
7	Width of Pellet Die	Drg. No.	265 H/H	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/H / 15x8x5 H/H	
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 = 16 Both side
12	Tapping PCD		685 H/H	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 H/H	Tapping Depth 19 H/H
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							Counter - 65 Low - 36
2	External Relief Dia	_____	_____	_____	_____	_____	_____	_____	
3	External Relief Depth	_____	_____	_____	_____	_____	_____	_____	
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Keshav
6	Material Sent For Hardening On Date								21 3 24

Inspected By (Sign) & Date

Ravi 21/3/24

Reviewed by (Engineer-CNC)

Manager-QA