



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.		11354	55/60
2	Machined By		V.T.L. M/C Shop	Drill No. (L.O.) 494
3	Pallet Die No.		11548 (10.0) M/C	Rev=01
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	640 M/C	Step 002 62 M/C Tapper = 12°
6	Inside Diameter	Drg. No.	520.14 M/C	Step length = 18 M/C
7	Width of Pellet Die	Drg. No.	186 M/C	
8	Grooves as per Drawing	Drg. No.	13x8x3 M/C / 13x8x3 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		M202 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

Raoi 23/3/24

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 = 6°
2	External Relief Dia	10.5 M/C	Outside (3-3)		Inner			
3	External Relief Depth		10 M/C		5 M/C			
4	Inspection Done Before Hardening By (Name)							Raoi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		23	3	24			

Inspected By (Sign) & Date

Raoi 23/3/24

Reviewed by (Engineer-CNC)
Sate 23/3/24

Manager-QA