



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.		9856 to 9942	39/50
2	Machined By		V.T.L n/c Shop	Drg No. I.E.C.2998
3	Pallet Die No.		10633 (3.0) M4	Room 00
4	Die Category	Drg. No.	Extruder die	
5	Out Side Diameter	Drg. No.	619.7 M4 @ Step OD = Tapped 12" Step length 2.8 M	
6	Inside Diameter	Drg. No.	520.12 M4	
7	Width of Pellet Die	Drg. No.	222 M4	
8	Grooves as per Drawing	Drg. No.	13x8x5 M4 13x8x5 M4	
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		565 M4	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 M4 Tapping Depth 18.8 M4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Saoi 12/7/23

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							Room 38
2	External Relief Dia	3.3 M4	Outside (2.3)		Inner				
3	External Relief Depth		17 M4		11 M4				
4	Inspection Done Before Hardening By (Name)								Saoi
5	Material Sent For Hardening By (Name)								Lark for name
6	Material Sent For Hardening On Date		12	7	23				

Inspected By (Sign) & Date

Saoi 12/7/23

Reviewed by (Engineer-CNC)

Manager-QA