



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.		9905	40/40
2	Machined By		V.T.L. N/C Shop	Drilling No. 1-8-D-762
3	Pallet Die No.		10331 (3-5) H	Revo 20
4	Die Category	Drg. No.	SE 20	
5	Out Side Diameter	Drg. No.	500 H, Step OD = 498.88	Tapping 10
6	Inside Diameter	Drg. No.	420.12 H	Step length = 18 H
7	Width of Pellet Die	Drg. No.	182 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H 12 x 8 x 3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping Hole diameter 8 Both Side
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		H20; Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.5 H	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pasi 18/7/23

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							Revo 22
2	External Relief Dia	4.0 H	Outside (2-2)	Inner					
3	External Relief Depth	✓	4 H	Mill					
4	Inspection Done Before Hardening By (Name)								Pasi
5	Material Sent For Hardening By (Name)								Lark Performance
6	Material Sent For Hardening On Date		18	7	23				

Inspected By (Sign) & Date

Pasi 18/7/23

Reviewed by (Engineer-CNC)

Manager-QA