



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11882	40/60
2	Machined By		V.T.L n/c Shop	Drg. No. 18.0584
3	Pallet Die No.		18229 (4.0) n/c	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c, 2 step 02, 798 n/c Tappers	
6	Inside Diameter	Drg. No.	660.12 n/c	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 n/c	Under cut 9 n/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 n/c 21.5 x 8 x 10 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H of 4-15, 12 Both Side
12	Tapping PCD		795 n/c	
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 31 n/c	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/5/24	2 Slot 32.1 n/c width 8 n/c Deep Both Side
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 - 3 Hole Closed	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Countersink
2	External Relief Dia	4.5 n/c	OK side (3.3)	Innen
3	External Relief Depth		24 n/c	20 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		10 5 24	
Inspected By (Sign) & Date			Ravi 10/5/24	

Reviewed by (Engineer-CNC)

Manager-QA