



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.			
2	Machined By		11948	34/47
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 1.8027767
4	Die Category	Drg. No.	12120 (3.2) mm	Res. 01
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	614 mm, Step 002 623.9 mm	Tap 12
7	Width of Pellet Die	Drg. No.	520.12 mm	Step length - 18 mm
8	Grooves as per Drawing	Drg. No.	222 mm	Under cut, 4.9 mm
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm / 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No of Holes = 12 Botu Side
13	Tapping Hole Diameter		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Belt ok	
15	Tapping Hole Depth		Drill Depth: 20.8 mm	Tapping Depth: 21.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/5/24

- As per programme no.
- Gun Drilling Work Completed On
- Hole Finish In Gun Drilling
- Defective Holes (If Any)

Marked

ok
No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 mm	outside (3.3)		Inner				
3	External Relief Depth		17 mm		13 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			16	5	24			

Inspected By (Sign) & Date

Ravi 16/5/24

Saty 16/5/24

Reviewed by (Engineer-CNC)

Manager-QA