



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.		9831	30/50 ✓
2	Machined By		V.T.L H/C Shop	
3	Pallet Die No.		9062 (5.0)mm	Qty Nos 1.30.333 Revised ✓
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	62mm ✓ Step 00: 623.6mm	Tappet = 12 ✓
6	Inside Diameter	Drg. No.	52.12mm	Step length = 2mm
7	Width of Pellet Die	Drg. No.	186mm	Under cut = 1.8mm ✓
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Tapping No of holes = 12 Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4mm	Tapping Depth: 18.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/7/23

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							Ravi 21
2	External Relief Dia	5.5mm	outside (3-3)		Inner				
3	External Relief Depth		25mm		down				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		5	7	23				

Inspected By (Sign) & Date

Ravi 5/7/23

Reviewed by (Engineer-CNC)

Manager-QA