



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.		9864	50/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.02/4951
3	Pallet Die No.		9408 (8.0) mm	Rev 2.00
4	Die Category	Drg. No.	Endrow side	
5	Out Side Diameter	Drg. No.	630 mm Step 00. 621.5 mm	Step length 21.5
6	Inside Diameter	Drg. No.	520.12 mm	Tapper 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		565 mm	of holes 12
13	Tapping Hole Diameter		12 mm Check by 12 mm Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/7/23

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 18
2	External Relief Dia	8.5 mm	Outside (3.3)		Inner				
3	External Relief Depth		13 mm		5 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		22	7	23				

Inspected By (Sign) & Date

Ravi 22/7/23

Reviewed by (Engineer-CNC)

Manager-QA