



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		12224 ✓	36/40
3	Pallet Die No.		N.T.L. m/c Shop	874
4	Die Category	Drg. No.	11758 (4.0) m/c	Rev 2.0
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	38.5 m/c Step OD, 38.3 m/c Step length	9.5
7	Width of Pellet Die	Drg. No.	305.12 m/c / 304.1 m/c	
8	Grooves as per Drawing	Drg. No.	12.5 m/c	m/c after hardening
9	Fitting Sizes on CNC Plate	Drg. No.	8x8x3 m/c / 8x8x3 m/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		m/c Shop	
13	Tapping Hole Diameter		350 m/c	Tapping Holes of Both Side
14	Tapping On Second Side	Half pitch of 1st side	MIG - Check by MIG Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 30.3 m/c	Tapping Depth = 30.5
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 31/7/24

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

Counter 63

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.3 m/c	outside (2-2)		inner				Rev 15
3	External Relief Depth		8 m/c		4 m/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		3	7	24				

Inspected By (Sign) & Date

Ravi 31/7/24

Satyam 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA