



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7859

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.		12400 ✓	23/50
2	Machined By		V.T.L. n/c Shop	Dy No. 13.0.450
3	Pallet Die No.		12330 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	730 n/c, Step 002 743.5 n/c	Tapping 10°
6	Inside Diameter	Drg. No.	630.12 n/c / 630.3 n/c	Step length 23 n/c
7	Width of Pellet Die	Drg. No.	290 n/c	Under cut, 6.75
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping dia of holes, 16 Retn Side
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		n/c, Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

19/7/24

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 - 2 hole closed

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

1	Counter Sinking Depth & Finish	OK					Counter 60° Low 42	
2	External Relief Dia	3.5 n/c, outside (3-3)		Inner				
3	External Relief Depth	23 n/c		17 n/c				
4	Inspection Done Before Hardening By (Name)		Lavi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		19	7	24			

Inspected By (Sign) & Date

19/7/24

Reviewed by (Engineer-CNC)

Manager-QA