



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.		12489	38/50
2	Machined By		N.T.L. n/c Shop	Dy. No. 1.8.998
3	Pallet Die No.		12584 (3.0) n/c	Rev. no.
4	Die Category	Drg. No.	Extraxside	
5	Out Side Diameter	Drg. No.	620 n/c	Step OD, Tappes 12' 3/4 length = 18.5
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of holes 12' Both Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		M20, Check by M20 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

Ravi 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

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

Count en = 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		18 n/c		12 n/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		19	7	24				

Inspected By (Sign) & Date

Ravi 19/7/24

Satish 20/7/24

Reviewed by (Engineer-CNC)

Manager-QA