



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.		12381	39/50
2	Machined By		V. T. C. n/c Shop	25-1
3	Pallet Die No.		12426(3.5) n/c	Rev 01
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	700 n/c Step 002-893 n/c	Tapping 12
6	Inside Diameter	Dr. No.	600.12 n/c	Step length 12 n/c
7	Width of Pellet Die	Dr. No.	222 n/c	
8	Grooves as per Drawing	Dr. No.	12x8x7 n/c 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Holes 12 Both Side
12	Tapping PCD		640 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

Counter, 60

1	Counter Sinking Depth & Finish	ok								Row = 28
2	External Relief Dia	4.0 n/c	outside (3-3)		inner					
3	External Relief Depth		18 n/c		11 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

Satyam
20/7/24
Reviewed by (Engineer-CNC)

Manager-QA