



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.		12278	45/50
2	Machined By		V.T.C H/c Shop	Dry Hole 6.8.2.18
3	Pallet Die No.		12782 (5.0) H/c	Revised
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	519.7 H/c Step ODs 490.7 H/c	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of Hole 3 on the Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.3 H/c	Tapping Depth = 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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						Counter 6.03 Rev: 90
2	External Relief Dia	5.3 H/c	208 side (2-2)	Inner				
3	External Relief Depth		10 H/c	5 H/c				
4	Inspection Done Before Hardening By (Name)		Rev:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		23	7	24			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA