



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.		11944	38/50
2	Machined By		M.T.C H/C Shop	Dy H., 1.2.0.9780
3	Pallet Die No.		12119 (3.0) H/H	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/H	Step OD = Tapper, 12°
6	Inside Diameter	Drg. No.	520.12 H/H	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping of holes, 12° Bolt Side
12	Tapping PCD		565 H/H	
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 H/H	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/24

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

1	Counter Sinking Depth & Finish	OK						Counter 260° Rev = 28
2	External Relief Dia	3.5 H/H	Outside (3-3)	Inner				
3	External Relief Depth		18 H/H	12 H/H				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		17	7	24			

Inspected By (Sign) & Date

Ravi 17/7/24

Reviewed by (Engineer-CNC)

Manager-QA