



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12557	27/47
2	Machined By		V. T. L h/c Shop	Drg No. 12557
3	Pallet Die No.		12813(3.0) h/c	Rev. 01
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	614 h/c	Step 00 = 61.5 h/c
6	Inside Diameter	Drg. No.	520.12 h/c	Tappe 12
7	Width of Pellet Die	Drg. No.	222 h/c	Step length = 31.5
8	Grooves as per Drawing	Drg. No.	222 h/c	Under cut = 3.75
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 h/c 13x8x5 h/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		h/c Shop	Tapping h/c
13	Tapping Hole Diameter		565 h/c	d hole = 12
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Ball	Back Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4 h/c	Tapping Depth = 18
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 7/8/24

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 6
2	External Relief Dia	3.5 h/c	Outside (3-3)		Inner				Rev. 01
3	External Relief Depth		23 h/c		Down				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Resource
6	Material Sent For Hardening On Date								7 8 24

Inspected By (Sign) & Date

Ravi 7/8/24

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Reviewed by (Engineer-CNC)

Manager-QA