



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.		12484 ✓	42/47.5 ✓
2	Machined By		V. TIL. H/c Shop	Drg. No. 12.02 982
3	Pallet Die No.		12899 (6.0) mm ✓	Rev. 01 ✓
4	Die Category	Drg. No.	Junior ✓	
5	Out Side Diameter	Drg. No.	414.9 mm ✓	Step on. 382.8 mm Step length. 98
6	Inside Diameter	Drg. No.	320.12 mm ✓	
7	Width of Pellet Die	Drg. No.	125.8 mm ✓	
8	Grooves as per Drawing	Drg. No.	10 x 8 x 3 mm / 9.8 x 8 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok ✓	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		355 mm ✓	
13	Tapping Hole Diameter		03/4 ✓ 2 Check by 03/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth. 21 mm	Tapping Depth. 19.5 ✓
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Bas. 22/8/24

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 60 Rev. 11
2	External Relief Dia	6.5 mm	Outside (2-2)	Inner					
3	External Relief Depth	11 mm		5 mm					
4	Inspection Done Before Hardening By (Name)								Bas. ✓
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		22	8	24				

Inspected By (Sign) & Date

Bas. 22/8/24

Bas. 22/8/24

Reviewed by (Engineer-CNC)

Manager-QA