



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.		12607	28/50
2	Machined By		N.T.G. H/c Shop	Dry No. 1.8.02 419
3	Pallet Die No.		12543(4.0) H/c	Rev. No.
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c Shop	Tapping No. of Holes, 12 Both Side
12	Tapping PCD		645 H/c	
13	Tapping Hole Diameter		M202 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 22.4 H/c	Tapping Depth 20.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/8/24

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 Kans 32
2	External Relief Dia	4.5 H/c	outside (3-3)		Inner			
3	External Relief Depth		26 H/c		22 H/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		23	8	24			

Inspected By (Sign) & Date

Ravi 23/8/24

Satish 23/8/24

Reviewed by (Engineer-CNC)

Manager-QA