



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.		12813	31/45
2	Machined By		V.T.L. H/c Shop	Dr. No. 62.0.644
3	Pallet Die No.		12818 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 H/c	Step 00, 621.5 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Tapped = 12 Step length = 81.5
7	Width of Pellet Die	Drg. No.	222 H/c	Order cost = 575
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		N20 Check by N20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth = 18.5
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° Rows = 29	
2	External Relief Dia	3.1 H/c	3.1 H/c All Rows	
3	External Relief Depth		10 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	

Reviewed by (Engineer-CNC)
23/8/24

Manager-QA