



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.		12651	40/53
2	Machined By		V. T. L. n/c Shop	Dy. Insp. 18.02.13
3	Pallet Die No.		12665 (8.0) n/c	Rev. 1.00
4	Die Category	Drg. No.	Juniors	
5	Out Side Diameter	Drg. No.	410 n/c, Step 00, 380 n/c	Step length 10.8
6	Inside Diameter	Drg. No.	304.12 n/c	
7	Width of Pellet Die	Drg. No.	121 n/c	
8	Grooves as per Drawing	Drg. No.	8.5 x 7 x 2 n/c / 8.5 x 7 x 2 n/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 = 8 Back Side
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		M12 = Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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 8
2	External Relief Dia	8.5 n/c	8.0 side (2-2)	Inner			
3	External Relief Depth		17 n/c	13 n/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		22	28	24		

Inspected By (Sign) & Date

Ravi 22/8/24

Reviewed by (Engineer-CNC)

Manager-QA