



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.		12422	48/66
2	Machined By		V. T. L. H/c Shop	Dy. Insp. L.S.D. 095
3	Pallet Die No.		12926 (8.0) H/c	Rev. Insp.
4	Die Category	Drg. No.	M. Jambur	
5	Out Side Diameter	Drg. No.	880 H/c 1st step 00, 890.5 H/c	Tappes 5°
6	Inside Diameter	Drg. No.	548.12	
7	Width of Pellet Die	Drg. No.	215 H/c	
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 8 H/c 30.5 x 6 x 8 mm	6 x 8 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	1st & 2nd side
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		620 H/c	of holes, 2
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32 H/c	Tapping Depth 30.5
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

4 Defective Holes (If Any)

No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter 30°

1 Counter Sinking Depth & Finish

ok

Row 2 12

2 External Relief Dia

9.0 H/c

All Rows

3 External Relief Depth

18 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

23/8/24

Reviewed by (Engineer-CNC)

Manager-QA