



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.		10002	44/50
2	Machined By		V.T.L. H/c Shop	Dry No. 1-EC-998
3	Pallet Die No.		10592 (4.0) H/H	Rev 2013
4	Die Category	Drg. No.	2nd side wide	
5	Out Side Diameter	Drg. No.	620.1 H/H Step 007 Tapper, 12° Step Length=18	
6	Inside Diameter	Drg. No.	520.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H 13x8x5 H/H	
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 = 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		M20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H Tapping Depth 18.8 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 9/8/23

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							Raw: 9/8/23
2	External Relief Dia	4.5 H/H	outside (2-3)		Inner				
3	External Relief Depth		14 H/H		6 H/H				
4	Inspection Done Before Hardening By (Name)								Raw:
5	Material Sent For Hardening By (Name)								Lark Forware
6	Material Sent For Hardening On Date								9 8 23

Inspected By (Sign) & Date

Raw: 9/8/23

[Signature]
9/8/23

Reviewed by (Engineer-CNC)

Manager-QA