



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.		12860	Go/Go
2	Machined By		V.T.L. n/c Shop	Dry Hoz. I.S.D. = 413
3	Pallet Die No.		12854 (5.0) n/c	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 n/c	Step OD: 693 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber = 12'
7	Width of Pellet Die	Drg. No.	222 n/c	Step length = 20 n/c
8	Grooves as per Drawing	Drg. No.	1478 x 7 n/c	1478 x 7 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20 = Check by M2 Bolt	Tapping Hole of Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.4 n/c	Tapping Depth = 22.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/9/24

- 1 As per programme no.
- 2 Gun Drilling Work Completed On
- 3 Hole Finish In Gun Drilling
- 4 Defective Holes (If Any)

Marked

ok

No

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

1	Counter Sinking Depth & Finish	ok							Counter B...
2	External Relief Dia	5.5 n/c	outside (3-3)		Inner				Row = 26
3	External Relief Depth	/	10 n/c		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			14	9	24			

Inspected By (Sign) & Date

Ravi 14/9/24

Signature 14/9/24

Reviewed by (Engineer-CNC)

Manager-QA