



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.		10005	30/40/55
2	Machined By		V.T.L n/c Shop	Dy No. 18.0.412
3	Pallet Die No.		9712(4.8)mm	Rev 2009
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	Flange Step OD: 692.8mm	Step lengths 2mm
6	Inside Diameter	Drg. No.	600.12mm	Tabes: 12
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	14x8x7mm 14x8x7mm	
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 12 Beta Side
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.5mm	Tapping Depth 22.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 11/8/23

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							
2	External Relief Dia	5.3mm 5.8mm	5.3mm	All Lines	5.8mm	All Lines			Ravi-22
3	External Relief Depth		25mm		15mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		11	8	23				

Inspected By (Sign) & Date

Ravi: 11/8/23

Reviewed by (Engineer-CNC)

Manager-QA