



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.			
2	Machined By		12938 ✓	40/55
3	Pallet Die No.		V.T.L M/c Shop	Drg No. 1.2.02/14924
4	Die Category	Drg. No.	12648(5.0)H4 ✓	Recess ✓
5	Out Side Diameter	Drg. No.	Extrawide	
6	Inside Diameter	Drg. No.	630H4 ✓	Step OD 612.4H4 ✓
7	Width of Pellet Die	Drg. No.	520.12H4 ✓	Step length 19.5 ✓
8	Grooves as per Drawing	Drg. No.	222H4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5H4 / 13x8x5H4 ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping H of Holes = 12 Both Side
13	Tapping Hole Diameter		565H4 ✓	
14	Tapping On Second Side	Half pitch of 1st side	H20: Check by H20 Bolt ✓	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4H4 ✓	Tapping Depth = 18.5 ✓
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 30/9/24

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	5.5H4 ✓	outside (3-3)		Inner					Rows = 26 ✓
3	External Relief Depth		20H4 ✓		15H4 ✓					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date				30	09	24			

Inspected By (Sign) & Date

Ravi 30/9/24

Reviewed by (Engineer-CNC)

Manager-QA