



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.		12891	56/60
2	Machined By		V. T. L. n/c Shop	Drg No. 18.0.650
3	Pallet Die No.		13490 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	64.0 n/c	Step on 64.0 n/c
6	Inside Diameter	Drg. No.	58.0 ± 0.12 n/c	Step length 18.0 n/c
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	13487.5 n/c	13487.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping of Holes is Done by V. T. L. Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

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

1	Counter Sinking Depth & Finish	OK						Counter 2.00
2	External Relief Dia	4.5 n/c	Outside (3-3)	Inner				Low 2.31
3	External Relief Depth		12 n/c	4 n/c				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		30	9	24			

Inspected By (Sign) & Date

Ravi 30/9/24

Reviewed by (Engineer-CNC)

Manager-QA