



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.		12982 ✓	36/50
2	Machined By		V.T.L n/c Shop	Dy. No. 1.A.12450
3	Pallet Die No.		12750(4.0) n/c ✓	Rev. No.
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730 n/c, Step OD = 743.5 n/c	Tapper 10°
6	Inside Diameter	Drg. No.	630.12 n/c	Step length = 83
7	Width of Pellet Die	Drg. No.	290 n/c	Under cut = 8.75
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping n/c of 1-12, 16 Beta Side
12	Tapping PCD		685 n/c ✓	
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 = 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 8/10/24	
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 = 60° Rev = 48
2	External Relief Dia	4.5 n/c	Outside (3-3)	Inner
3	External Relief Depth		18 n/c	14 n/c
4	Inspection Done Before Hardening By (Name)		Ravi ✓	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8	10 24
Inspected By (Sign) & Date			Ravi 8/10/24	

Reviewed by (Engineer-CNC)

Manager-QA