



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.		13048	88/50
2	Machined By		V. T. L. n/c. Shop	Drg No. 13.02.344
3	Pallet Die No.		12004 (2.8) n/c	Rev 2.00
4	Die Category	Drg. No.	N7912	
5	Out Side Diameter	Drg. No.	700 n/c Step 002 698 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 n/c [Box = 601.4 n/c]	
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c / 15x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping dia of holes 16 Bottom Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M202 Check by H20 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 9/10/24	
1	As per programme no.		_____	Approved By Neeraj Sir
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 Ravi = 49
2	External Relief Dia	3.3 n/c	Outside (3-3)	Inner
3	External Relief Depth		25 n/c	22 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		9 10 24	
Inspected By (Sign) & Date			Ravi 9/10/24	

Reviewed by (Engineer-CNC)

Manager-QA