



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.		12715 ✓	31/47
2	Machined By		V.T.L. H/c Shop	Qty No. 18.0.875
3	Pallet Die No.		13012 (2.8) H/c	Rev 2.00
4	Die Category	Drg. No.	Extrude	(A)
5	Out Side Diameter	Drg. No.	614 H/c ✓ step 00. 623.5 H/c / 623.1 H/c	
6	Inside Diameter	Drg. No.	520.12 H/c	Tapper = 12°
7	Width of Pellet Die	Drg. No.	222 H/c	Step length = 18 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	Order cut = 4.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		56.5 H/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 H/c	Tapping Depth = 18.6 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter = 60

1	Counter Sinking Depth & Finish	OK							Row 2 40
2	External Relief Dia	3.3 H/c ✓	Outside (3-3)		Inner				
3	External Relief Depth		22 H/c ✓		18 H/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			14	10	24			

Inspected By (Sign) & Date

Ravi 14/10/24

Reviewed by (Engineer-CNC)

Manager-QA