



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.		13176	36/55
2	Machined By		V. TIL n/c Shop	Dry Hole 1.8.0. 453
3	Pallet Die No.		12131(4.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	JEN	
5	Out Side Diameter	Drg. No.	740 n/c Step 002 743.5 n/c	
6	Inside Diameter	Drg. No.	630.12 n/c	Tapper 10°
7	Width of Pellet Die	Drg. No.	290 n/c	Step length 2.3 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c 15x8x5 n/c	Under cut 1.75
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 holes = 16 Back 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 20.8 n/c	Tapping Depth 8.6
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60° Rev. 43
2	External Relief Dia	4.5 n/c	outside (3-3)	inner
3	External Relief Depth		23 n/c	19 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		14 10 24	
Inspected By (Sign) & Date			Ravi 14/10/24	

Reviewed by (Engineer-CNC)

Manager-QA