



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.		12762	29/47
2	Machined By		N.T.L. n/c Shop	Dr. H. S. 15/10/24
3	Pallet Die No.		13016 (2.8) n/c	Rev. 00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	614 n/c Step 002 612 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 n/c 520.3 n/c	
7	Width of Pellet Die	Drg. No.	221.6 n/c	
8	Grooves as per Drawing	Drg. No.	13.8 x 8 x 5 n/c / 12.8 x 8 x 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 H. of Holes: 12 Both Side
12	Tapping PCD		565 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 15/10/24	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter = 6 Rep. 40
2	External Relief Dia	3.1 n/c	Outside (3-3)	Inner
3	External Relief Depth		20 n/c	18 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		15	10 24
Inspected By (Sign) & Date			Ravi 15/10/24	

Jatya 15/10/24

Reviewed by (Engineer-CNC)

Manager-QA