



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.		13181 ✓	36/50 ✓
2	Machined By		V. T. L H/c Shop	Drg No. 1.20.9980
3	Pallet Die No.		12577 (4.5) ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	9 x 29 wide	
5	Out Side Diameter	Drg. No.	620 ✓	Step 00.2 Tap hole 12°
6	Inside Diameter	Drg. No.	520.12 ✓	Step length 18.5 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 ✓	13 x 8 x 5 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes: 12 Both Side
12	Tapping PCD		565 ✓	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 ✓	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

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

Counters 60°

1	Counter Sinking Depth & Finish	OK								Rev 2.29
2	External Relief Dia	5.0 ✓	outside (3-3)		inner					
3	External Relief Depth		19 ✓		14 ✓					
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

Satyam 15/10/24

Reviewed by (Engineer-CNC)

Manager-QA