



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.		13074	28/50
2	Machined By		V.T.L. N/C Shop	Dy No. 1.3.02 419
3	Pallet Die No.		12560 (4.0) H4	Rev: 00
4	Die Category	Drg. No.	Mr. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4 Step OD = 692 H4	Step length 9.5
6	Inside Diameter	Drg. No.	600.12 H4	
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H4 / 12.5 x 8 x 7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		645 H4	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.3 H4	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/10/24

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

Counter 60

1	Counter Sinking Depth & Finish	OK							Rev: 32
2	External Relief Dia	4.5 H4	Outside (3-3)		Inner				
3	External Relief Depth		26 H4		22 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forrace
6	Material Sent For Hardening On Date		16	10	24				

Inspected By (Sign) & Date

Ravi 16/10/24

Satya 16/10/24

Reviewed by (Engineer-CNC)

Manager-QA