



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.		12880 ✓	45/50 ✓	
2	Machined By		V.T.L. N/C Shop	Dry Hole L-FCU 10969	
3	Pallet Die No.		12986 (3.5) ✓	Revised ✓	
4	Die Category	Drg. No.	Jumbo		
5	Out Side Diameter	Drg. No.	76044 ✓ Step 00, 792 ✓	Step length 97 ✓	
6	Inside Diameter	Drg. No.	66012 ✓	Undercut 216 ✓	
7	Width of Pellet Die	Drg. No.	324 ✓		
8	Grooves as per Drawing	Drg. No.	2148x10 ✓ / 2148x10 ✓		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		N/C Shop	Tapping No. of 4-12.12 Both Side	
12	Tapping PCD		725 ✓		
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 273 ✓	Tapping Depth 255 ✓	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 16/10/24	2 Slot	
1	As per programme no.		—	38.144 width 9mm Depth Both Side	
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		Count on 60	
2	External Relief Dia	4.044	Outside (3-3)	Rev. 51	
3	External Relief Depth		124 ✓	544 ✓	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		16	10	24
Inspected By (Sign) & Date			Ravi 16/10/24		

Reviewed by (Engineer-CNC) *Satya* 16/10/24

Manager-QA