



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.		13214	66/66
2	Machined By		V.T.L. H/c Shop	Drg. No. 12.02 32
3	Pallet Die No.		13332(10.0)H	Rev. 05
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H H	Step 00.692 H H
6	Inside Diameter	Drg. No.	548. H H	Tapper 8°
7	Width of Pellet Die	Drg. No.	215 H H	Step length 31 H H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H H	Under cut 2.8 H H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step 2 H H Deep B.H.M
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H H	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Tapping No. of Holes = 4 B.H.M
14	Tapping On Second Side	Half pitch of 1st side	OK	Side
15	Tapping Hole Depth		Drill Depth 34.8 H H	Tapping Depth 32 H H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/10/24

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 Sink Rev. 8
2	External Relief Dia							no - Retial
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date							21 10 24
Inspected By (Sign) & Date		Ravi 21/10/24						

Reviewed by (Engineer-CNC)

Manager-QA