



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.		13027 ✓	32150 ✓
2	Machined By		V.T.L. N/C Shop	Dr. No. 18.02.493
3	Pallet Die No.		12557 (2.8) H4 ✓	Rev. No. ✓
4	Die Category	Drg. No.	M Jumbo	
5	Out Side Diameter	Drg. No.	700 H4, Step 002 693 H4	Step length 2mm ✓
6	Inside Diameter	Drg. No.	600.12 H4 ✓	
7	Width of Pellet Die	Drg. No.	222 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H4 / 12x10x7.5 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		640 H4 ✓	
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 H4	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

Counter: 60

1	Counter Sinking Depth & Finish	ok							Ravi: 40 ✓
2	External Relief Dia	3.1 H4 ✓	00 Side (3-3)		Inner				
3	External Relief Depth		23 H4 ✓		18 H4 ✓				
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