



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.			
2	Machined By		12899 ✓	25/69 ✓
3	Pallet Die No.		V.T.C n/c Shop	26/69 ✓
4	Die Category	Drg. No.	12914(6.5) n/c ✓	Drg. No. L.S. 823
5	Out Side Diameter	Drg. No.	Jumbo	Rev. 100 ✓
6	Inside Diameter	Drg. No.	838 n/c ✓	Step 001 847 8 n/c ✓
7	Width of Pellet Die	Drg. No.	700 n/c ✓	Step length 30.5 ✓
8	Grooves as per Drawing	Drg. No.	240 n/c ✓	Under cut 1.8 n/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	29x10x8 n/c / 29x10x8 n/c ✓	(6x8) n/c ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	[Fore side 30.1 n/c ✓ [Back Both side ✓
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		765 n/c ✓	[Tapping n/c ✓ [of holes ✓ [Both side ✓
14	Tapping On Second Side	Half pitch of 1st side	MIG ✓ Check by MIG Bolt ✓ ok	
15	Tapping Hole Depth		Drill Depth 32 n/c ✓	Tapping Depth 30.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/10/24

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 20° ✓ Rev 16 ✓
2	External Relief Dia	7.5 n/c ✓	1st Pad	2nd Pad					
3	External Relief Depth		4 n/c ✓	43 n/c ✓					
4	Inspection Done Before Hardening By (Name)		Ravi ✓						
5	Material Sent For Hardening By (Name)		Lark Rorone						
6	Material Sent For Hardening On Date		19	10	24				

Inspected By (Sign) & Date

Ravi 19/10/24

Reviewed by (Engineer-CNC)
Satya 19/10/24

Manager-QA