



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.		13083	51/55
2	Machined By		V.T.L. M/c. Shop	Drg No. 6302
3	Pallet Die No.		12224(3.8)M	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530M	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12M	
7	Width of Pellet Die	Drg. No.	158M	
8	Grooves as per Drawing	Drg. No.	12x8x3M	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c. Shop	
12	Tapping PCD		454M	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		0.31" = Check by 0.31" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.3M	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/10/24

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

Counters 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3M	Outside (2-2)		Inner				
3	External Relief Depth		11M		4M				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		22	10	24				

Inspected By (Sign) & Date

Ravi 22/10/24

Satish 22/10/24

Reviewed by (Engineer-CNC)

Manager-QA