



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8451

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.		13159	36/55
2	Machined By		V.T.L n/c stop	Drg No. 1.3.02 B47
3	Pallet Die No.		12644 (G.O) n/c	Low
4	Die Category	Drg. No.	Extraxide	
5	Out Side Diameter	Drg. No.	630 n/c	Step OD = 604 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Tapper = 12° Step length = 18 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c stop	Tapping Holes of Holes = 12 Both Side
12	Tapping PCD		565 n/c	
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 n/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/10/24

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 = 630

1	Counter Sinking Depth & Finish	ok						Low = 23
2	External Relief Dia	6.5 n/c	Outside (3-3)		Inner			
3	External Relief Depth		25 n/c		19 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		30	10	24			

Inspected By (Sign) & Date

Ravi 30/10/24

Reviewed by (Engineer-CNC)
Sats 30/10/24

Manager-QA