



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.		13055 ✓	25/39 ✓
2	Machined By		V.T.C. H/c Shop	Dry Hole L.S.D. Tool
3	Pallet Die No.		13262 (2.5) ✓	Recess ✓
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	598 ✓	Step OD 2.812 ✓
6	Inside Diameter	Drg. No.	520.12 ✓	Step length ✓
7	Width of Pellet Die	Drg. No.	222 ✓	Undercut 2.7 ✓
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 ✓	Tapping No. of Holes, 12
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.4 ✓	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/11/24

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 - 3 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter, 60°
Rows = 42

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	2.8 ✓	2.8	All Rows		
3	External Relief Depth			14 ✓		
4	Inspection Done Before Hardening By (Name)			Ravi		
5	Material Sent For Hardening By (Name)			Lark Furnace		
6	Material Sent For Hardening On Date			5 11 24		

Inspected By (Sign) & Date

Ravi 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA