



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.		13011	40/50
2	Machined By		V.T.L. n/c Shop	Drill Holes 12.0 x 12.50
3	Pallet Die No.		12567 (4.0) mm	Recess
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm	Step length 20 mm
6	Inside Diameter	Drg. No.	600.12 mm	Tapkes. 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		640 mm	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 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/11/24

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

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

1	Counter Sinking Depth & Finish	OK					Counter = 600
2	External Relief Dia	4.5 mm	outside (3-3)		Inner		Row = 32
3	External Relief Depth		14 mm		10 mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		6	11	24		

Inspected By (Sign) & Date

Ravi 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA