



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13211 ✓	40/50 ✓
2	Machined By		V. T. L. H/c Shop	Dr. H. L. S. 12501
3	Pallet Die No.		12569 (4.0) H/c	Rev. 2.0 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c	Step OD = 693 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Tap hole = 12 ✓
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 H/c	12 x 8 x 7 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		640 H/c	Tapping No. of holes = 12
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	Rotu Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.3 H/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/11/24

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 = 60
2	External Relief Dia	4.5 H/c	Outside (2.3)		Inner			Row = 38
3	External Relief Depth		14 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ramesh
6	Material Sent For Hardening On Date		9	11	24			

Inspected By (Sign) & Date

Ravi 9/11/24

Reviewed by (Engineer-CNC)

Manager-QA