



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.		13227	45/50
2	Machined By		V. T. L. n/c Shop	Dry No. 13.2 = 1180
3	Pallet Die No.		11871(5.0) n/c	Rev. n/c
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	620 n/c Step OD: 623.3 n/c	Tabber = 12°
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 2 n/c
7	Width of Pellet Die	Drg. No.	186 n/c	Outer cut = 1.6 n/c
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping No. of holes, 12] [Bottom Side]
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		MIG - Check by MIG Roll	
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 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 - 1 Hole Colored

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

Counter, 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		10 n/c		5 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Burnace				
6	Material Sent For Hardening On Date		9	11	24				

Inspected By (Sign) & Date

Ravi 9/11/24

Sats 9/11/24

Reviewed by (Engineer-CNC)

Manager-QA