



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.		13226 ✓	40/50
2	Machined By		V. T. L. n/c Shop	Dy. No. 13.02.245
3	Pallet Die No.		12570 (3.2) ✓	Rev. 01 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm Step 002 693 mm	Tapping 12
6	Inside Diameter	Drg. No.	600.12 mm ✓	Step length 20 mm
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	14x8x7 mm 14x8x7 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping of holes 12 Beta Side
12	Tapping PCD		640 mm ✓	
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 22.3 mm	Tapping Depth 20.0
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 - 1 Hole Closed (A)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Countersink 238
2	External Relief Dia	3.8 mm	Outside (3-3)	
3	External Relief Depth		16 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		5 11 24	
Inspected By (Sign) & Date			Ravi 5/11/24	

Satyam 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA