



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.		13328 ✓	40/40 ✓
2	Machined By		V.T.L n/a Shop	Dy. No. 120/1508
3	Pallet Die No.		11828 (4.0) n/a ✓	Rev. No. ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/a Step OD = 498.88 n/a Tapper = 12	
6	Inside Diameter	Drg. No.	420.12 n/a ✓	Step length = 18 n/a ✓
7	Width of Pellet Die	Drg. No.	158 n/a ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/a / 12x8x3 n/a ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	[Tapping No. of holes = 8 Both Side]
12	Tapping PCD		454 n/a ✓	
13	Tapping Hole Diameter		120, Check by 120 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 n/a Tapping Depth = 15.5	
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.		_____	convert from
2	Gun Drilling Work Completed On		_____	Taper to
3	Hole Finish In Gun Drilling	Marked	ok	S.t. After
4	Defective Holes (If Any)		No	Hard

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

Counters 80

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/a	Outside (2-2)	Inner					
3	External Relief Depth		5 n/a	Mill					
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