



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.		12405	35/50
2	Machined By		V.T.L. H/C Shop	Dr. No. 18.02/250
3	Pallet Die No.		12492 (3.0) H/C	Revol
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C Step OD = 693 H/C	Step length 10mm
6	Inside Diameter	Drg. No.	600.12 H/C	Tapped 12°
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C 12x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	Tapping No. of holes = 12 Back Side
13	Tapping Hole Diameter		M2 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	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

Counter = 6°
Low = 39

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 H/C	Outside (3-3)	Inner			
3	External Relief Depth		2 H/C	15 H/C			
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