



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.		13484 ✓	37/45 ✓
2	Machined By		V.T.L. H/c Shop	Dy. No. 18015430
3	Pallet Die No.		12511 (3.0) H/c	Rec. No.
4	Die Category	Drg. No.	8 x 29 wide	
5	Out Side Diameter	Drg. No.	610 H/c	Step length 2mm
6	Inside Diameter	Drg. No.	590.12 H/c	Under cut 1mm
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	Tapping No. of Holes 12 Both Side
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 20.4 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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 6.0
2	External Relief Dia	3.5 H/c	30 Side (3-3)		Inner			38
3	External Relief Depth		14 H/c		8 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		25	11	24			

Inspected By (Sign) & Date

Ravi 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA