



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.		13400 ✓	33/40
2	Machined By		V.T.C. n/c Shop	Dry No. 1.50.15.62
3	Pallet Die No.		12705 (3.0) n/c ✓	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step 00, 498.88	Tappet 2 12°
6	Inside Diameter	Drg. No.	480.12 n/c	Step length 12.19 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping N. of Hole P. Both Side
12	Tapping PCD		454 n/c	
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: 18.4 n/c	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/11/24

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 60°

1	Counter Sinking Depth & Finish	ok								Low = 24
2	External Relief Dia	3.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth	✓	13 n/c		7 n/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									28 " 24

Inspected By (Sign) & Date

Ravi 28/11/24

Reviewed by (Engineer-CNC)

Manager-QA