



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.		13402	38/50	
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.02965	
3	Pallet Die No.		12865(5.0) n/c	Rev 200	
4	Die Category	Drg. No.	M. Jumbo		
5	Out Side Diameter	Drg. No.	700 n/c Step OD = 694 n/c	Step length 4.20 n/c	
6	Inside Diameter	Drg. No.	600.12 n/c	Tapper = 12°	
7	Width of Pellet Die	Drg. No.	222 n/c		
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c / 12 x 8 x 7 n/c		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Shop	Tapping No of Holes = 12 Both Side	
12	Tapping PCD		640 n/c		
13	Tapping Hole Diameter		H22 Check by H22 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth = 22.3 n/c	Tapping Depth = 22.6	
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		Ravi	
2	External Relief Dia	5.3 n/c	Outside (3-3)	Inner	
3	External Relief Depth		17 n/c	12 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	11	24
Inspected By (Sign) & Date			Ravi 28/11/24		

Reviewed by (Engineer-CNC)

Manager-QA