



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.		13289	30/40
2	Machined By		V.T.L. M/C Shop	Degrees 13.92 194
3	Pallet Die No.		10658 (3.0) M/C	Rev. 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 M/C Step 00, 381 M/C	Step length 9.4
6	Inside Diameter	Drg. No.	310.12 M/C	
7	Width of Pellet Die	Drg. No.	125 M/C	
8	Grooves as per Drawing	Drg. No.	7x5.5x4 M/C 7x5.5x4 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		351 M/C	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		Ø36" = Check by Ø36" Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 15.3 M/C Tapping Depth 13.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/11/24

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							
2	External Relief Dia	Ø3.3 M/C	outside (2-2)	Inner					
3	External Relief Depth		13 M/C	10 M/C					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Fornace						
6	Material Sent For Hardening On Date		27	11	24				

Inspected By (Sign) & Date

Ravi 29/11/24

Satish 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA