



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.		13404 ✓	36/55 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. 13.02.407
3	Pallet Die No.		13867 (4.0) ✓	Rev 1.00 ✓
4	Die Category	Drg. No.	M. Jamba	
5	Out Side Diameter	Drg. No.	710 ✓ / Step on: 692 ✓	Tabber: 12 ✓
6	Inside Diameter	Drg. No.	600.12 ✓	Step length: 20 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 ✓ / 12x8x7 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping dia of hole = 12 Both Side
12	Tapping PCD		640 ✓	
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 ✓	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 - 1 Hole Closed (B)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.5 ✓	Outside (3-3)		Inner					
3	External Relief Depth		23 ✓		19 ✓					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		28		11		24			

Inspected By (Sign) & Date

Ravi 28/11/24

Reviewed by (Engineer-CNC)

Manager-QA