



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.		12752 ✓	20/80 ✓
2	Machined By		V.T.L. n/c Shop	Drg. No. 12.0.978
3	Pallet Die No.		13812(3.5) n/c ✓	Rev. 2.00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 n/c ✓	Step 00, 743.5 n/c
6	Inside Diameter	Drg. No.	630.12 n/c ✓	Tapper 1/8"
7	Width of Pellet Die	Drg. No.	265 n/c ✓	Step length 23 n/c ✓
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5 n/c ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		685 n/c ✓	Tapping No. of Holes = 16 Both Side
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6 n/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/11/24

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

1	Counter Sinking Depth & Finish	ok					Counter 60
2	External Relief Dia	—	—	No	Retry		Row 42
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Keshav		
6	Material Sent For Hardening On Date		26	11	24		

Inspected By (Sign) & Date

Ravi 26/11/24

Satyam 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA