



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.		13365 ✓	40/45 ✓
2	Machined By		V.T.L. n/a Shop	Dy. No. 12.02.1904
3	Pallet Die No.		12640(6.0) n/a	Rev 2.00 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.544 / Step 002 389.744	Step length 9.4
6	Inside Diameter	Drg. No.	31.5144 ✓	9.2 ✓
7	Width of Pellet Die	Drg. No.	146 n/a	
8	Grooves as per Drawing	Drg. No.	15x8x3 n/a / 15x8x3 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		356 n/a ✓	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		03/4" Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28.344 Tapping Depth 26.5	
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 12
2	External Relief Dia	6.544	outside (2-2)		Inner				
3	External Relief Depth	/	1144		544				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								R.R
6	Material Sent For Hardening On Date		26	11	24				

Inspected By (Sign) & Date

Ravi 28/11/24

Satyam 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA