



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.		13487 ✓	42/55 ✓
2	Machined By		N.T.L. N/C Shop ✓	Drg. No. 1.8.02420
3	Pallet Die No.		13871 (6.0) ✓	Rev. no
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	70mm, Step 60 = 69.2mm ✓	Step length 19.4
6	Inside Diameter	Drg. No.	60.12mm ✓	
7	Width of Pellet Die	Drg. No.	22.2mm ✓	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7mm / 12.5 x 8 x 7mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping dia of holes = 12 Both Side
12	Tapping PCD		64.5mm ✓	
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 22.3mm Tapping Depth 20.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/2/24

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							Rev. 23
2	External Relief Dia	6.5mm	Outside (23-3)		Inner				
3	External Relief Depth		19mm		13mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			2	12	24			

Inspected By (Sign) & Date

Ravi 21/2/24

Reviewed by (Engineer-CNC)

Manager-QA