



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)

87/2

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13214 ✓	55/55
3	Pallet Die No.		V.T.L. H/c Shop	Dy. No. 18.D.1030
4	Die Category	Drg. No.	13404 (10.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	Flt H/c, Step on, 692 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	300.12 H/c	
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	36x10x7 H/c / 36x10x7 H/c	✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		645 H/c ✓	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 19.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/12/24

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
Rows = 9

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	_____	_____	No Relief			
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		6	12	24		

Inspected By (Sign) & Date

Ravi 6/12/24

Sats 10/12/24

Reviewed by (Engineer-CNC)

Manager-QA