

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.			
2	Machined By		13534 ✓	44/50 ✓
3	Pallet Die No.		N.T.L. H/c Shop	Dy No. 1-20-9980
4	Die Category	Drg. No.	13476(4.0) H/H	Rev 100 ✓
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	6.20 H/H, Step 002	Tapping = 12"
7	Width of Pellet Die	Drg. No.	5.20.12 H/H	Step length 42.135
8	Grooves as per Drawing	Drg. No.	222 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	1348x5 H/H / 1373x5 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	[Tapping No of holes 12 Roh Side]
13	Tapping Hole Diameter		56.5 H/H	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/H	outside (3-3)		Inner				
3	External Relief Depth		14 H/H		6 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forge				
6	Material Sent For Hardening On Date			11	12	24			

Inspected By (Sign) & Date

Ravi 11/12/24

Sot 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA