



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		13520	30/50
3	Pallet Die No.		N.T.L. H/c Shop	Drg No. L.E.C.29980
4	Die Category	Drg. No.	13652 (3.0) H/c	Rev 2.00
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	620 H/c Step OD. Tapper: 12°	
7	Width of Pellet Die	Drg. No.	520.12 H/c	Step length: 18.5
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth: 20.4 H/c	Tapping Depth: 18.6
17	Visual Inspection Before Gun Drilling		yes OK	

Inspected By (Sign) & Date

Ravi 12/12/24

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

1	Counter Sinking Depth & Finish	OK					Counter: 6°
2	External Relief Dia	3.5 H/c	outside (3-3)		Inner		Lab 238
3	External Relief Depth		23 H/c		20 H/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		12	13	24		

Inspected By (Sign) & Date

Ravi 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA