



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13565	40/40
2	Machined By		V.T.L N/C Shop	Drg No. 1.3.2=788
3	Pallet Die No.		13119 (4.0) H4	Rev 2.00
4	Die Category	Drg. No.	S910	
5	Out Side Diameter	Drg. No.	500H4 Step OD = 498.38	Tapped 12
6	Inside Diameter	Drg. No.	420.12 H4	Step length 18.3
7	Width of Pellet Die	Drg. No.	12.8 H4	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 H4 12.8 x 3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454 H4	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H4	Tapping Depth 16.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/12/24

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 = 60°
2	External Relief Dia	4.5 H4	Outside (2-2)	Inner				Rev 2.5
3	External Relief Depth		4 H4	Nil				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Purnore					
6	Material Sent For Hardening On Date		14	12	24			

Inspected By (Sign) & Date

Ravi 14/12/24

Reviewed by (Engineer-CNC)

Manager-QA