



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		13543 ✓	40/50 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 1.2.0.14805
4	Die Category	Drg. No.	12013 (4.0) ✓	Rev. 02 ✓
5	Out Side Diameter	Drg. No.	M7 & W	
6	Inside Diameter	Drg. No.	701 ✓ Step OD, Tappers 12°	
7	Width of Pellet Die	Drg. No.	600.12 ✓	Step length = 17.1
8	Grooves as per Drawing	Drg. No.	265 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x7 ✓ / 15x8x7 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping no of holes = 16 Both Side
13	Tapping Hole Diameter		640 ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M2 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.3 ✓ Tapping Depth = 18.6	
17	Visual Inspection Before Gun Drilling		yes 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 ✓	20 Side (3-3)		Inner				Row = 39
3	External Relief Depth		14 ✓		10 ✓				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			11	12	24			

Inspected By (Sign) & Date

Ravi 11/12/24

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA