



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.		13581	32/50
2	Machined By		V.T.C H/O Shop	Drg No. 1202980
3	Pallet Die No.		13482(3.0) H/O	Reason
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 H/O Step 00 - Tapper. 12°	
6	Inside Diameter	Drg. No.	520.12 H/O	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 H/O	
8	Grooves as per Drawing	Drg. No.	1348 x 5 H/O / 1348 x 5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping No of Holes = 12 Back Side
12	Tapping PCD		565 H/O	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/O Tapping Depth = 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/12/24

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° Roz = 38
2	External Relief Dia	3.5 H/O	Outside (3-3)		Inner		
3	External Relief Depth		2 H/O		18 H/O		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		16	12	24		

Inspected By (Sign) & Date

Ravi 16/12/24

Reviewed by (Engineer-CNC)

Manager-QA