



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.		12328	80/65.5
2	Machined By		V.T.C. n/c Shop	Dy. No. 680, 908
3	Pallet Die No.		14076 (12.0) n/c	Rev. 03
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	639.7 n/c, 3 step 00, 652.3 n/c	Tapper = 8"
6	Inside Diameter	Drg. No.	508.8 n/c (10 step - 539.7/523.78)	Step length = 32 n/c
7	Width of Pellet Die	Drg. No.	175.1 n/c	
8	Grooves as per Drawing	Drg. No.	30x21x7.25 n/c 9x25 n/c	Face Side Step 0.5 n/c Deep
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 = 4
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 2nd side 4 slot	
15	Tapping Hole Depth		Drill Depth = 30.3 n/c Tapping Depth = 28.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/12/24

1	As per programme no.		ok	4 slot 51.5 n/c Long 98 n/c width 15 n/c Deep
2	Gun Drilling Work Completed On		ok	
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								Rev = 5
2	External Relief Dia	12.5 n/c	All Pairs							
3	External Relief Depth		5.5 n/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			18	12	24				

Inspected By (Sign) & Date

Ravi 18/12/24

Signature 18/12/24

Reviewed by (Engineer-CNC)

Manager-QA