



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.		13631	28/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 12.02.939
3	Pallet Die No.		13922 (2.8) n/c	Rev. 00
4	Die Category	Drg. No.	Tombo	
5	Out Side Diameter	Drg. No.	760 n/c	Step length 28 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Tapper 9.5°
7	Width of Pellet Die	Drg. No.	316 n/c	Eden cut = 20.5 n/c
8	Grooves as per Drawing	Drg. No.	18 x 9 x 6 n/c / 18 x 9 x 6 n/c	
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 12 Both Side
12	Tapping PCD		725 n/c	
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 22.3 n/c	Tapping Depth 20.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/12/24

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 - 1 Hole Colored (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Go

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 n/c	Outside (3-3)		Inner				
3	External Relief Depth		25 n/c		22 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fornere
6	Material Sent For Hardening On Date		19	12	24				

Inspected By (Sign) & Date

Ravi 19/12/24

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA