



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 M/C Shop	Drg. No. 13.0.939
3	Pallet Die No.		13291 (2.8) H/H	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H/H, Step OD = 801 H/H, Tapper, 9.5	
6	Inside Diameter	Drg. No.	660.12 H/H	Step length = 28 H/H
7	Width of Pellet Die	Drg. No.	316.2 H/H	Undercut = 20.5 H/H
8	Grooves as per Drawing	Drg. No.	18x9x6 H/H / 18x9x6 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		795 H/H	
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 = 22.3 H/H	Tapping Depth = 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/12/24

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 - Hole Colused (A)

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							Rev. 59
2	External Relief Dia	3.3 H/H	Outside (3-3)		Inner				
3	External Relief Depth		25 H/H		22 H/H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark For race
6	Material Sent For Hardening On Date		23	12	24				

Inspected By (Sign) & Date

Ravi 23/12/24

Reviewed by (Engineer-CNC)

Manager-QA