



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.		13678	30/47
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.801531
3	Pallet Die No.		12514(3.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	614 n/c Step OD. 612 n/c	Step length. 19.5
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Hole of Hole. 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20x Check by M20 Pail	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/12/24

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° Rev. 2.38
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner			
3	External Relief Depth		20 n/c		17 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		26	12	24			

Inspected By (Sign) & Date

Ravi 26/12/24

Ravi 26/12/24

Reviewed by (Engineer-CNC)

Manager-QA