



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.			
2	Machined By		13701	36/50
3	Pallet Die No.		V.I.L. H/C Shop	Drg. No. L.E.C-9980
4	Die Category	Drg. No.	13684(3.0) H/C	Rev. 00
5	Out Side Diameter	Drg. No.	Centerside	
6	Inside Diameter	Drg. No.	620 H/C Step OD: Tapper, 12°	
7	Width of Pellet Die	Drg. No.	520.12 H/C	Step length = 18.5
8	Grooves as per Drawing	Drg. No.	922 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	Tapping Ho of Holes = 12 Both Side
13	Tapping Hole Diameter		565 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H2 = 2 Check by H2 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.3 H/C Tapping Depth = 18.6 H/C	
17	Visual Inspection Before Gun Drilling		Yes	

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

Counters = 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	3.5 H/C	Outside (3-3)		Inner					Rev = 38
3	External Relief Depth		20 H/C		14 H/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

Reviewed by (Engineer-CNC)

Manager-QA