



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.			
2	Machined By		13729 ✓	36/50 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dy. H. 18.07.12
4	Die Category	Drg. No.	13653(3.0) ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	Extre wide	
6	Inside Diameter	Drg. No.	620H ✓ Step 00. Tapper, 12°	
7	Width of Pellet Die	Drg. No.	520.12 ✓	Step length 18.5 ✓
8	Grooves as per Drawing	Drg. No.	222 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5H ✓ 13x8x5H ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		565H ✓	
14	Tapping On Second Side	Half pitch of 1st side	N2 = Check by H2 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 20.2H ✓ Tapping Depth: 18.6H ✓	
17	Visual Inspection Before Gun Drilling		yes ok	
Inspected By (Sign) & Date			Ravi 28/11/24	
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. 28
2	External Relief Dia	13.5H ✓	Outside (3-3)	Inner
3	External Relief Depth		20H ✓	14H ✓
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28	12 24
Inspected By (Sign) & Date			Ravi: 28/11/24	

Reviewed by (Engineer-CNC)

Manager-QA