



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.		13988	30/50
2	Machined By		V.T.C. H/c Shop	Drg No. 13.0.578
3	Pallet Die No.		13745(3.0) H/c	Revised
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 H/c, Step 00 = 615.5 H/c	Tapper, 4°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 25 H/c
7	Width of Pellet Die	Drg. No.	222.1 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/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		565 H/c	
13	Tapping Hole Diameter		M2 x 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/1/25

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

Counter = 60
Rev = 38

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.3 H/c	Outside (3.3)	Inner			
3	External Relief Depth		23 H/c	20 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Porrace				
6	Material Sent For Hardening On Date		16	1	25		

Inspected By (Sign) & Date

Ravi 16/1/25

Satya 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA