



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.		10386 ✓	38/50
2	Machined By		V.T.L. H/C Shop	Dy No. 1.2.0.9980
3	Pallet Die No.		10807 (3.0) H/C	Rev = 00 ✓
4	Die Category	Drg. No.	2-side	
5	Out Side Diameter	Drg. No.	6.20 H/C, Step OD, Tapper = 12° Step length = 18.5	
6	Inside Diameter	Drg. No.	5.90 H/C	
7	Width of Pellet Die	Drg. No.	22.2 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		H/C Shop	Tapping No. of Holes = 12 Both side
12	Tapping PCD		56.5 H/C	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/C Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/10/23

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 - 1 Hole Colused

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

1	Counter Sinking Depth & Finish	ok							Rev = 98
2	External Relief Dia	3.5 H/C	outside (3-3)		inner				
3	External Relief Depth		18 H/C		12 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			11	10	23			

Inspected By (Sign) & Date

Ravi 11/10/23

Reviewed by (Engineer-CNC)
11/10/23

Manager-QA