



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.		10586 ✓	50/50
2	Machined By		V.T.L. H/C Shop	Drg No. L.E.C. 13760
3	Pallet Die No.		11348 (2.0) ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520H ✓ Step OD. 491H ✓	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H ✓	
7	Width of Pellet Die	Drg. No.	158 H ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H ✓ 12x8x3 H ✓	
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. 8 Both Side
12	Tapping PCD		450 H ✓	
13	Tapping Hole Diameter		M20. Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 19.8 H ✓	Tapping Depth 17.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/11/23	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Row 2 12
2	External Relief Dia	8.5 H ✓	Outside (2-2)	Inner
3	External Relief Depth		4 H ✓	Mill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		8 11 23	
Inspected By (Sign) & Date			Ravi 8/11/23	

Reviewed by (Engineer-CNC)

Manager-QA