



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.		10653 ✓	40/50 ✓
2	Machined By		V. T.L. NLC Shop	Drg No. 18.02 493 ✓
3	Pallet Die No.		9969 (8.0) ✓	Rev 200 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 ✓ Step 60 = 692.8 ✓	Tapper = 12 ✓
6	Inside Diameter	Drg. No.	600.12 ✓ / 600.14 ✓	Step length = 20 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 ✓ / 12 x 10 x 7.5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		NLC Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		640 ✓	
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 ✓	Tapping Depth = 18.8 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/11/23	
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		Low = 18
2	External Relief Dia	8.5 ✓	Outside (3-31)	Inner
3	External Relief Depth		18 ✓	10 ✓
4	Inspection Done Before Hardening By (Name)		Ravi ✓	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		15	23
Inspected By (Sign) & Date			Ravi 15/11/23	

Reviewed by (Engineer-CNC)

Manager-QA