



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.		10854	39/50
2	Machined By		V.T.L H/C Shop	Dry run L&C=9980
3	Pallet Die No.		11240(3.0) H/C	Rev=00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	6.25 H/C, Step 0.2, Tabble=12, Step length=18mm	
6	Inside Diameter	Drg. No.	5.20-12 H/C	
7	Width of Pellet Die	Drg. No.	222 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		564.9 H/C / 565 H/C	
13	Tapping Hole Diameter		M2x2 Check by H2-Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.3 H/C Tapping Depth 19mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/12/23

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							Rev=38
2	External Relief Dia	3.3 H/C	Outside (3-3)		Inner				
3	External Relief Depth		17 H/C		11 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forward				
6	Material Sent For Hardening On Date		15	12	23				

Inspected By (Sign) & Date

Ravi 15/12/23

Reviewed by (Engineer-CNC)

Manager-QA