



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.		10854	42/50
2	Machined By		V.T.L. n/c Shop	Drg Nos L3.0.71
3	Pallet Die No.		11242 (4.0) n/c	Rev 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 n/c / Step OD = 620.3 n/c	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 17 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut = 1.15 n/c
8	Grooves as per Drawing	Drg. No.	9x10x4 n/c / 9x10x4 n/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 n/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 = 21.3 n/c	Tapping Depth = 19 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 22/1/24

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							Counters = 60°
2	External Relief Dia	u.3 n/c	outside (3-3)		inner				
3	External Relief Depth		12 n/c		8 n/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		22	1	24				

Inspected By (Sign) & Date Ravi 22/1/24

Reviewed by (Engineer-CNC) [Signature] 22/1/24

Manager-QA