



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.		10934 ✓	45/50
2	Machined By		V.T.L. M/c Shop	Drg No. I.S.C. 13780
3	Pallet Die No.		11332 (4.0) M ✓	Rev = 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 M ✓	Step OP, 49 M ✓
6	Inside Diameter	Drg. No.	420.12 M ✓	Step length = 17.5 ✓
7	Width of Pellet Die	Drg. No.	158 M ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 M ✓	12 x 8 x 3 M ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok ✓	
11	Tapping Operator		M/c Shop	Tapping No of holes = 8 Both Side ✓
12	Tapping PCD		454 M ✓	
13	Tapping Hole Diameter		M202 Check by new Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth 19 M ✓	Tapping Depth 17 M ✓
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Ravi 26/11/23

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

Count on = 60°

1	Counter Sinking Depth & Finish	ok ✓							
2	External Relief Dia	4.5 M ✓	outside (2-2)		inner				
3	External Relief Depth		13 M ✓		5 M ✓				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		26	12	23				

Inspected By (Sign) & Date

Ravi 26/11/23

Reviewed by (Engineer-CNC)

Manager-QA