



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.		10907	31/40
2	Machined By		V.T.L. H/c Step	Drg No. L-30,942
3	Pallet Die No.		11856 (A.3) H/H	Rep-00
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	600 H/H Step OD = 621.4 H/H	Step length = 21.5 H/H
6	Inside Diameter	Drg. No.	520.12 H/H	Tapper = 12°
7	Width of Pellet Die	Drg. No.	222 H/H	Load cut = 10.65 H/H
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Step	Tapping No of holes = 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H202 Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21 H/H Tapping Depth = 19 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 2/1/24

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 - 4 Hole Closed ^(B)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

1	Counter Sinking Depth & Finish	OK							Rep = 39
2	External Relief Dia	3.3 H/H		All Rows					
3	External Relief Depth			6 H/H					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date			2	1	24			

Inspected By (Sign) & Date

Ravi 2/1/24

Reviewed by (Engineer-CNC)
S. S. 2/1/24

Manager-QA