



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.		11119	50/60
2	Machined By		V.T.C. u/a Shop	Drg No. 1.8.0 = 409
3	Pallet Die No.		10200 (4.0) u/a	Rev. 00
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	640 u/a, Step OD: 612 u/a	Step length: 9.4
6	Inside Diameter	Drg. No.	520.12 u/a	
7	Width of Pellet Die	Drg. No.	186 u/a	
8	Grooves as per Drawing	Drg. No.	13x8x3 u/a 13x8x3 u/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of 4.12.12 Both Side
12	Tapping PCD		565 u/a	
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 u/a	Tapping Depth: 19 u/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/11/24	
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		Counter = 60° Row = 25
2	External Relief Dia	4.5 u/a	outside (3-3)	Inner
3	External Relief Depth		18 u/a	10 u/a
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		22	24
Inspected By (Sign) & Date			Ravi 22/11/24	

Reviewed by (Engineer-CNC)

Manager-QA