



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.		11106	35/50
2	Machined By		N.T. Gupta Shop	Drg No. L.E.C. 9980
3	Pallet Die No.		11459 (4.0) H4	Rev. 00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	62 H4, Step OD, Tapper 12°	
6	Inside Diameter	Drg. No.	52.12 H4	Step length = 13.5
7	Width of Pellet Die	Drg. No.	22.2 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping Holes of 12° Both Side
12	Tapping PCD		56.5 H4	
13	Tapping Hole Diameter		H20.2 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 H4	Tapping Depth = 19 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/1/24

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					Counter 60°
2	External Relief Dia	4.5 H4	Outside (3-3)	Inner			Rev 2 31
3	External Relief Depth		19 H4	15 H4			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Bornece				
6	Material Sent For Hardening On Date		19	1	24		

Inspected By (Sign) & Date

Ravi 19/1/24

Reviewed by (Engineer-CNC)

Manager-QA