



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.			
2	Machined By		11153	53/58
3	Pallet Die No.		V.T.L. n/c Shop	Dr. No. 1-3.0.2
4	Die Category	Drg. No.	11558 = (3.8) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	716.1 n/c	Step 002 692.1 n/c Step length 19.4
7	Width of Pellet Die	Drg. No.	600.12 n/c	
8	Grooves as per Drawing	Drg. No.	222.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of 4-12.12 Bolt side
12	Tapping PCD		645 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 = 23.5 n/c	Tapping Depth = 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/1/24

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	4.3 n/c	Outside (3.3)	Inner				Ratio = 33
3	External Relief Depth		12 n/c	5 n/c				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark for more
6	Material Sent For Hardening On Date		23	1	24			

Inspected By (Sign) & Date

Ravi 23/1/24

23/1/24

Reviewed by (Engineer-CNC)

Manager-QA