



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.		9851	39/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.F.C. 2501
3	Pallet Die No.		10226 (2.0) n/c	Rev. 201
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Shop OD. 693 n/c	Step length 20 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber = 12
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c 12 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20 n/c Tapping Depth 18.8 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 10/7/23

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 - 1 Hole Closed

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

1	Counter Sinking Depth & Finish	OK								Row = 39
2	External Relief Dia	3.5 n/c	Out Side (3-3)		Inner					
3	External Relief Depth	✓	17 n/c		11 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			10	7	23				

Inspected By (Sign) & Date

Ravi 10/7/23

Reviewed by (Engineer-CNC)

Manager-QA