



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.		10976	30/60
2	Machined By		V.T.L. n/c Stop	Drg No. 13.02.654
3	Pallet Die No.		10910 (G.O.) n/c	Rev. no.
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	720 n/c, Step 002 692 n/c	Step length = 19.4
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	36x10x7 n/c / 36x10x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Stop	Tapping dia of hole = 12 Back 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 21.4 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 11/2/24

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

Marked

4 Defective Holes (If Any)

No

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

Counter = 60

1 Counter Sinking Depth & Finish

OK

Rev. 10

2 External Relief Dia

7.0 n/c

All Rows

3 External Relief Depth

30 n/c

4 Inspection Done Before Hardening By (Name)

Ravi

5 Material Sent For Hardening By (Name)

Lark Ramesh

6 Material Sent For Hardening On Date

1

2

24

Inspected By (Sign) & Date

Ravi 11/2/24

Reviewed by (Engineer-CNC)

Manager-QA