



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)

6935

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10693/	30/50
3	Pallet Die No.		V.T.L. n/a Shop	Dy. No. L-2.029980
4	Die Category	Drg. No.	11080 (3.0) n/a	Rev. 00
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	620.1 n/a Step 002 Tapper. 12° Step length 18 n/a	
7	Width of Pellet Die	Drg. No.	520.12 n/a 520.14 n/a	
8	Grooves as per Drawing	Drg. No.	222 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/a 13x8x5 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/a Shop	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		565 n/a	
14	Tapping On Second Side	Half pitch of 1st side	n/a = Check by H20 Bolt	
15	Tapping Hole Depth		Drill Depth: 21.0 n/a Tapping Depth: 19 n/a	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/2/24

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

Counter 60

1	Counter Sinking Depth & Finish	ok								Rows 38
2	External Relief Dia	3.5 n/a	outside (3-3)		Inner					
3	External Relief Depth		23 n/a		20 n/a					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date			12	2	24				

Inspected By (Sign) & Date

Ravi 12/2/24

Reviewed by (Engineer-CNC)

Manager-QA