



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.		11300	27/35/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.22.07
3	Pallet Die No.		11574 (5.0) n/c	Rev 200
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c	Step OD 692.8 n/c
6	Inside Diameter	Drg. No.	600.12 n/c / 600.14 n/c	Step length 18.8
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 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 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
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/8/24

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								
2	External Relief Dia	5.5 n/c / 6.0 n/c	5.5 n/c All Rows	6.0 n/c All Rows						Rev 25
3	External Relief Depth		28 n/c	20 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		14	2	24					

Inspected By (Sign) & Date

Ravi 14/8/24

Reviewed by (Engineer-CNC)

Manager-QA