



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11248	Q28/50
2	Machined By		V.T.L H/c Stop	Drg No. L.E.C.13614
3	Pallet Die No.		8894 (3.0) H/H	Reo2 00
4	Die Category	Drg. No.	NJEW	
5	Out Side Diameter	Drg. No.	700 H/H Step 002 692 H/H	Step length 19.4
6	Inside Diameter	Drg. No.	600.12 H/H	
7	Width of Pellet Die	Drg. No.	265 H/H	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/H / 15x8x7 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Stop	Tapping n/c of Holes, 12 Retn Side
12	Tapping PCD		640 H/H	
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 H/H Tapping Depth: 19 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/8/24

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 - 3 Hole Colosed

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

Counter 80°
Low = 48

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 H/H	Outside (3-3)		Inner		
3	External Relief Depth		18 H/H		12 H/H		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date			16	2	24	

Inspected By (Sign) & Date

Ravi 16/8/24

Satyam 16/2/24