



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

6992

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11960	40/48/55
2	Machined By		V.T.L. H/c Shop	Drg No. L.S.D. 800
3	Pallet Die No.		11636 (6.0) H/c	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	Flower Step 00: 692.8 H/c	Tapping 12°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 19.8
7	Width of Pellet Die	Drg. No.	22.22 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes 12 Roth Side
12	Tapping PCD		640 H/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 21.3 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/8/24

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

1	Counter Sinking Depth & Finish	ok					Counter 22.60
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Rows	7.0 H/c All Rows			Rev 2.22
3	External Relief Depth		15 H/c	7 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Fornerce				
6	Material Sent For Hardening On Date		22	24			

Inspected By (Sign) & Date

Ravi 22/8/24

S. J. 22/8/24

Reviewed by (Engineer-CNC)

Manager-QA