



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.		11334	40/55	
2	Machined By		V.T.L n/c Shop	Drg. No. 14.01.14984	
3	Pallet Die No.		11356 (8.0)mm	Rev. 00	
4	Die Category	Drg. No.	8 outside		
5	Out Side Diameter	Drg. No.	630mm, Step 002 612mm	Step length 17.5	
6	Inside Diameter	Drg. No.	590.12mm		
7	Width of Pellet Die	Drg. No.	222mm		
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm		
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		565mm		
13	Tapping Hole Diameter		M20 Check by M20 Roll		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 21.3mm Tapping Depth 19mm		
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 21/3/24		
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 60' Rev 18	
2	External Relief Dia	8.5mm	outside (3-3)		
3	External Relief Depth		20mm	15mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		2	3	24
Inspected By (Sign) & Date			Ravi 21/3/24		

Reviewed by (Engineer-CNC)

Manager-QA