



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.		11443	32/50
2	Machined By		V.T.L n/c Shop	Drg No. 6.3.02 419
3	Pallet Die No.		11222 (4.0) n/c	Rev=00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c, Step OD = 692 n/c	Step length = 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 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		645 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 = 22.8 n/c	Tapping Depth = 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/3/24

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°
2	External Relief Dia	4.5 n/c	outside (3-3)	Inner			Lat = 32
3	External Relief Depth		22 n/c	18 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		6	3	24		

Inspected By (Sign) & Date

Ravi 6/3/24

Reviewed by (Engineer-CNC)

Manager-QA