



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.		11468	40/55
2	Machined By		N.T.L. n/c Shop	Dr. No. 1.8.02/4924
3	Pallet Die No.		11949 (5.0) n/c	Rev. 00
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	629.8 n/c (A) Step 002 812 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 n/c 520.14 n/c (A)	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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		565 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 20.8 n/c Tapping Depth 19.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 16/3/24

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 26
2	External Relief Dia	5.5 n/c	Outside 29.31	Inner			
3	External Relief Depth		20 n/c	15 n/c			
4	Inspection Done Before Hardening By (Name)		Sasi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		16	3	24		

Inspected By (Sign) & Date

Sasi 16/3/24

Reviewed by (Engineer-CNC)

Manager-QA