



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7117 2012

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.		10781	34/50
2	Machined By		V.T.L H/c Shop	Drg No. 1-20-9980
3	Pallet Die No.		11070 (2.8) H/c	Rev 2.0
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	620 H/c - Step 002 Tapper 12° Step length 18.5	
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 12° Bolt side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.7 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 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						Count 20
2	External Relief Dia	3.3 H/c	outside (3-3)		Inner			Rev 2 H/c
3	External Relief Depth		22 H/c		16 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Porrace			
6	Material Sent For Hardening On Date		16	3	24			

Inspected By (Sign) & Date

Ravi 16/3/24

Reviewed by (Engineer-CNC)

Manager-QA