



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.		11531	39/50
2	Machined By		V. T. L. n/c Shop	Drg. No. 62019805
3	Pallet Die No.		8898 (3.0) n/c	Rev. cd
4	Die Category	Drg. No.	MJERD	
5	Out Side Diameter	Drg. No.	701 n/c, Step 002	Tapping 12° Step length 17
6	Inside Diameter	Drg. No.	600.14 n/c	
7	Width of Pellet Die	Drg. No.	985 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c 15x8x7 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 = 18 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.5 n/c	Tapping Depth 19 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/3/24

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

Counter 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 n/c	outside (2-3)		inner				
3	External Relief Depth		17 n/c		11 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		19	3	24				

Inspected By (Sign) & Date

Ravi 19/3/24

Reviewed by (Engineer-CNC)
Satsar 19/3/24

Manager-QA