



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.		11354/	55/60
2	Machined By		V. T. L. n/c Shop	Drg. No. I.S.O. 494
3	Pallet Die No.		11549 (10.0) n/c	Revised
4	Die Category	Drg. No.	58850	
5	Out Side Diameter	Drg. No.	640 n/c Step 00, 624 n/c	Tappers 12
6	Inside Diameter	Drg. No.	520.14 n/c (P)	Step length 18
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Hole of holes 12 Bottom 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 18.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/3/24

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 Ravi 22/3/24
2	External Relief Dia	10.5 n/c	outside (3.3)		inner				
3	External Relief Depth		10 n/c		5 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Ruvracc
6	Material Sent For Hardening On Date		22	3	24				

Inspected By (Sign) & Date
Ravi 22/3/24

Ravi 22/3/24

Reviewed by (Engineer-CNC)

Manager-QA