



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

7217

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11564	40/50/55
2	Machined By		V. T. L. H/C Shop	By H/c Lark Shop
3	Pallet Die No.		11981 (B.2) H/C	
4	Die Category	Drg. No.	External die	
5	Out Side Diameter	Drg. No.	6.20 H/C Step 0.02 6.12 H/C Step length 19.4	
6	Inside Diameter	Drg. No.	5.20 1.4 H/C (A)	
7	Width of Pellet Die	Drg. No.	22.2 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		56.5 H/C	
13	Tapping Hole Diameter		M 20.2 Check by H 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 H/C	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/3/24

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 600

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.8 H/C	00.8 side (B-3)		Inner				
3	External Relief Depth		16 H/C		10 H/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					3	24		

Inspected By (Sign) & Date

Ravi 30/3/24

Reviewed by (Engineer-CNC)

Manager-QA