



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.		11609	3040
2	Machined By		V.T.C. n/c Shop	Drg No. 1.8.0.91
3	Pallet Die No.		11300 (3.0) n/c	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c, Step 00, 499 n/c	Tabber: 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 7mm
7	Width of Pellet Die	Drg. No.	158.1 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Holes, 2 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		Ø3/4" ± Check by Ø3/4" B. 12	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19 n/c Tapping Depth: 17 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/3/24

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 25
2	External Relief Dia	3.5 n/c	outside (2-2)		Inner			
3	External Relief Depth		13 n/c		10 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		28	3	24			

Inspected By (Sign) & Date

Ravi 28/3/24

Reviewed by (Engineer-CNC)

Manager-QA