



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.		11654	35/50
2	Machined By		V. T. G. H/C Shop	Drg No = 189.415
3	Pallet Die No.		12180 (2.0) H/C	Rev = 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C Step 00, 499 H/C	Tabber 12
6	Inside Diameter	Drg. No.	420.14 H/C	Step length 3.2 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes = 8 Both Side
12	Tapping PCD		454 H/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 = 18.4 H/C	Tapping Depth = 16.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/4/24

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 - 1 Hole Closed

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	4.5 H/C	outside (2-2)		Inner			
3	External Relief Depth		18 H/C		14 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							

Inspected By (Sign) & Date

Ravi 21/4/24

Reviewed by (Engineer-CNC)

Manager-QA