



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7231

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.		11648	40/48/55
2	Machined By		V.T.L. H/C Shop	Dy No. 15.0.66
3	Pallet Die No.		12137 (6.0) H/C	Rev: 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	Flower Step 001 692-8 H/C	Tabber 12
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 2 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/C / 12x10x7.5 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 = 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20 Check by New 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 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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	OK							Rem: 22
2	External Relief Dia	6.5 H/C / 7.0 H/C	6.5 H/C All Rows	7.0 H/C All Rows					
3	External Relief Depth		15 H/C		7 H/C				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Rorware						
6	Material Sent For Hardening On Date		2	4	24				

Inspected By (Sign) & Date

Ravi 21/4/24

Reviewed by (Engineer-CNC)
Sajeev 21/4/24

Manager-QA