



Lark Engineering Company (India) Pvt. Ltd.

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

7311

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.		11703	39/52
2	Machined By		V. T. L. n/c Shop	Dy. No. 68.0.549
3	Pallet Die No.		12141 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	704 n/c, Step 002 693 n/c	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 2mm
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c / 12x10x7.5 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 12° Both Side
12	Tapping PCD		640 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
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 12/4/24

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

1	Counter Sinking Depth & Finish	ok							Counter 28
2	External Relief Dia	3.5 n/c	Outside 3.3		Inner				
3	External Relief Depth		19 n/c		13 n/c				
4	Inspection Done Before Hardening By (Name)								Raoi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		12	4	24				

Inspected By (Sign) & Date

Raoi 12/4/24

Reviewed by (Engineer-CNC)

Manager-QA