



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.		11769	45/50
2	Machined By		V.T.L. M/C Shop	Dy. No. 1202 13760
3	Pallet Die No.		11705 (6.0)	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520.144	Step 002 491.144 Step length 174
6	Inside Diameter	Drg. No.	420.1244	
7	Width of Pellet Die	Drg. No.	15844	
8	Grooves as per Drawing	Drg. No.	12x8x344 / 12x8x344	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes - 8 Both Side
12	Tapping PCD		45444	
13	Tapping Hole Diameter		M20x2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.844 Tapping Depth 16.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/4/24	
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							Count per 60
2	External Relief Dia	6.544	outside (2-2)		Inner			Rev 2-15
3	External Relief Depth		1144		544			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		13	4	24			

Inspected By (Sign) & Date

Ravi 13/4/24

Reviewed by (Engineer-CNC)

Manager-QA