



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.		11834	30/47
2	Machined By		V. T. L. H/C Shop	Drg No. 1.2.015431
3	Pallet Die No.		11615 (3-0) H/C	Row 200
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	614 H/C, Step 60, 612 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 13x8x5 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 Rake Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20 = Check by H2 = Ball	
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

Row: 18/4/24

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 60 Row = 38
2	External Relief Dia	3.5 H/C	20 Side (3-3)		Inner				
3	External Relief Depth		20 H/C		17 H/C				
4	Inspection Done Before Hardening By (Name)								Row:
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			18	4	24			

Inspected By (Sign) & Date

Row: 18/4/24

Reviewed by (Engineer-CNC)

Manager-QA