



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.		9644	18/66
2	Machined By		N.T.C. n/c Shop	Drg No. 1.3.0.609
3	Pallet Die No.		10588 (6.0) n/c	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step OD = 692.8 n/c	Tapping 2°
6	Inside Diameter	Drg. No.	548.14	Step Length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Undercut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8.1 n/c 32 x 7 x 8.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side Step 8 n/c Back Both Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping No. of Holes = 4 Both Side]
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/23

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 (A)

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

1	Counter Sinking Depth & Finish	ok					Counter = 30° Ravi = 12
2	External Relief Dia	7.5 n/c	7.5 n/c	All Lines			
3	External Relief Depth			48 n/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			21	7	23	

Inspected By (Sign) & Date

Ravi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA