



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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11858	28/36/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.0.47
3	Pallet Die No.		12148 (4.0) n/c	Row 20
4	Die Category	Drg. No.	N. 70 n/c	
5	Out Side Diameter	Drg. No.	710 n/c, Step 00.693 n/c	Tabber 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.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 12 Rate 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			Ravi 6/5/24	
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 - 1 Hole Colused	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60° Row 20
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Rows / 5.0 n/c All Rows	
3	External Relief Depth		27 n/c / 19 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		6 5 24	
Inspected By (Sign) & Date			Ravi 6/5/24	

Reviewed by (Engineer-CNC)

Manager-QA