



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	28/35/55
2	Machined By		V.T.C. H/C Shop	Qty 12. 24. 27
3	Pallet Die No.		12147 (4.10) H/C	Rev. 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C Step 002 692.8 H/C	Tabber 12
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 2.00
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C 12x8x7 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 Both side
12	Tapping PCD		640 H/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 H/C	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/5/24

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 Closed

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

Counters 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.5 H/C 5.0 H/C	4.5 H/C	All Rows	5.0 H/C	All Rows				
3	External Relief Depth		27 H/C		19 H/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		7	5	24					

Inspected By (Sign) & Date

Ravi 24/5/24

24/5/24

Reviewed by (Engineer-CNC)

Manager-QA