



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.		11953	42/50
2	Machined By		V.T.C. H/C Shop	5855
3	Pallet Die No.		12059(3.0) H/C	2011-2012 (2011-12)
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/C Step OD, 612 H/C	3 step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	292 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 Holes of Holes 12 Bolt Side
12	Tapping PCD		565 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 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 10/5/24

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

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

1	Counter Sinking Depth & Finish	ok					Counter + 60
2	External Relief Dia	3.5 H/C	outside (3-3)	Inner			Part 38
3	External Relief Depth		14 H/C	8 H/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		10	5	24		

Inspected By (Sign) & Date

Ravi 10/5/24

Reviewed by (Engineer-CNC)

Manager-QA