



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.		11929 ✓	48/55 ✓
2	Machined By		V.T.L. n/c Shop	Drilling No. 1, 3, 9 3/045
3	Pallet Die No.		11944 (21.0) n/c	Reverse ✓
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	630 n/c Step 00, 621 n/c	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 2.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	14x8x9 n/c / 14x8x9 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 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20 n/c Tapping Depth = 18.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/5/24

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

Counter: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3 n/c	ok side (2-3)		Inner				
3	External Relief Depth		15 n/c		7 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			14	5	24			

Inspected By (Sign) & Date

Ravi 14/5/24

Reviewed by (Engineer-CNC)

Manager-QA