



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.		11841	40/48/55
2	Machined By		V.T.L. H/C Shop	Dr. No. 1.3.02.06 GC
3	Pallet Die No.		12027 (6.0)	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C, Step 00 = 692.8 H/C, Tappers 12°	
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 10mm
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/C 12x10x7.5 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 Hole 12 Back Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H202 Check by H20 Drill	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 H/C	Tapping Depth 12-8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 60 Rao: 22
2	External Relief Dia	6.5 H/C 7.0 H/C	6.5 H/C All Rows 7.0 H/C All Rows	
3	External Relief Depth	✓	15 H/C 7 H/C	
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6 5 24	
Inspected By (Sign) & Date			Rao: 6/5/24	

Reviewed by (Engineer-CNC)

Manager-QA