



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.	S.No.	Check Parameter	Specification	Observations	Remarks
1	1	Work Order No.		11998	412/55
2	2	Machined By		V.T.L. H/c Shop	Drilling 1.30.355
3	3	Pallet Die No.		12158(4.0) H/c	Pass
4	4	Die Category	Drg. No.	SSS7D	
5	5	Out Side Diameter	Drg. No.	630 H/c	Step 02-612 H/c Step length
6	6	Inside Diameter	Drg. No.	520.12 H/c	
7	7	Width of Pellet Die	Drg. No.	186 H/c	
8	8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 H/c	
9	9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	10	Drilling Area Surface Smoothness		OK	
11	11	Tapping Operator		H/c Shop	Tapping No. of Holes 12 Bottom Side
12	12	Tapping PCD		565 H/c	
13	13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	14	Tapping On Second Side	Half pitch of 1st side	OK	
15	15	Tapping Hole Depth		Drill Depth: 20.8 H/c	Tapping Depth: 19.8
16	16	Perpendicularity of Tapped Hole		Yes	
17	17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/5/24

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

1	Counter Sinking Depth & Finish	OK					Counter 25°
2	External Relief Dia	4.5 H/c	Outside (2-3)	Inner			Low 25
3	External Relief Depth		17 H/c	13 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		17	5	24		

Inspected By (Sign) & Date

Ravi 17/5/24

Satish 17/5/24

viewed by (Engineer-CNC)

Manager-QA