



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.		12207	42/55
2	Machined By		V. T. L. H/C Shop	Qty No. 1.3.02 1030
3	Pallet Die No.		12200 (8.0) H/C	Rev. No.
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C Step OD = 692 H/C	Step Length 19.5
6	Inside Diameter	Drg. No.	600.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	36 x 10 x 7 H/C / 36.1 x 10 x 7 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		645 H/C	
13	Tapping Hole Diameter		M20.2 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 26/6/24	
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		Count on = 65 Ravi 13
2	External Relief Dia	9.0 H/C	All Rows	
3	External Relief Depth		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		26 6 24	
Inspected By (Sign) & Date			Ravi 26/6/24	

Reviewed by (Engineer-CNC)

Manager-QA