



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.			
2	Machined By		12218	40/50
3	Pallet Die No.		V.T.L n/c Shop	Dy No. 18.00.91
4	Die Category	Drg. No.	12326 (4.0) n/c	Rev 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 n/c Step 00, 479 n/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	420.12 n/c	Step length 17 n/c
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12.2 8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes 8 Both Side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	0.314" = Check by 0.314" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 91.4 n/c	Tapping Depth: 8.5
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Rasi 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					Counters 60
2	External Relief Dia	4.5 n/c	Outside (2-2)		Inner		Rev: 20
3	External Relief Depth		14 n/c		10 n/c		
4	Inspection Done Before Hardening By (Name)						Rasi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		28	6	24		

Inspected By (Sign) & Date

Rasi 26/6/24

Reviewed by (Engineer-CNC)
 Sati 26/6/24

Manager-QA