



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		12307	33/50/6355
3	Pallet Die No.		V.T.L n/c Shop	Drig No. Lark 9310
4	Die Category	Drg. No.	12060 (3.0) n/c	
5	Out Side Diameter	Drg. No.	2nd grade	
6	Inside Diameter	Drg. No.	819.9 n/c Step 002 611.3 n/c Step length 19.5	
7	Width of Pellet Die	Drg. No.	520.2 n/c 520.3 n/c	
8	Grooves as per Drawing	Drg. No.	2.22 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of holes 12 Both Side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c 2 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.8 n/c	Tapping Depth 18.2
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 25/8/24

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
2	External Relief Dia	3.3 n/c	80 Side 3-3					Low 38
3	External Relief Depth		23 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		25	6	24			

Inspected By (Sign) & Date

Ravi 25/6/24

Satyam 25/6/24

Reviewed by (Engineer-CNC)

Manager-QA