

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.		12241 ✓	35/45/30
2	Machined By		V.T.L n/c Shop	Drg No. L.B.D. 700
3	Pallet Die No.		12076 (8.0) n/c	Row = 02
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 n/c, Step CD. 732 n/c / 632 n/c	
6	Inside Diameter	Drg. No.	572.1 n/c	Step lengths 20 n/c
7	Width of Pellet Die	Drg. No.	219 n/c	13.5 n/c
8	Grooves as per Drawing	Drg. No.	75x8x8 n/c / 58x8x8 n/c	Under cut = 1 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 6
12	Tapping PCD		650 n/c	
13	Tapping Hole Diameter		M16 = Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 1st side one slot	
15	Tapping Hole Depth		Drill Depth = 40.4 n/c Tapping Depth = 38.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/24

1	As per programme no.			1 Slot
2	Gun Drilling Work Completed On			36 n/c width
3	Hole Finish In Gun Drilling	Marked	ok	19 n/c Deep
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	8.5 n/c / 9.0 n/c	8.5 n/c All Rows	9.0 n/c All Rows		Row = 6
3	External Relief Depth		45 n/c	35 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		3	7	24	

Inspected By (Sign) & Date

Ravi 31/7/24

Satish 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA