



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.		12147	24/40
2	Machined By		N.T.L. H/c Shop	Dy H. 120.069
3	Pallet Die No.		12242 (3.0) H/c	Revised
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 H/c	Step 00. 389 H/c
6	Inside Diameter	Drg. No.	315.12 H/c	Step length 9.5
7	Width of Pellet Die	Drg. No.	120 H/c	
8	Grooves as per Drawing	Drg. No.	10x8x3 H/c / 10x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H of holes. 8 Both Side
12	Tapping PCD		356 H/c	
13	Tapping Hole Diameter		034" = Check by 034" Bore	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c	Tapping Depth. 18.5
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.		
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° Rev. 12
2	External Relief Dia	3.5 H/c	outside (2-2)		inner				
3	External Relief Depth		19 H/c		16 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			03	07	24			

Inspected By (Sign) & Date

Ravi 31/7/24

Reviewed by (Engineer-CNC)
Sats 31/7/24

Manager-QA