



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.		11158	35/40
2	Machined By		V.T.C. H/O Shop	Drg No. 1.2.5.1 5002
3	Pallet Die No.		10940 (3.5) H/O	Recess
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.00 H/O Step 00, 498.8 H/O	Tapper 12°
6	Inside Diameter	Drg. No.	4.20.12 H/O	Step length 18 H/O
7	Width of Pellet Die	Drg. No.	158 H/O	
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/O 12 x 8 x 3 H/O	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H/O of hole 8 Both side
12	Tapping PCD		454 H/O	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H/O	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/7/24

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 2.6
2	External Relief Dia	4.0 H/O	Outside (2-2)		Inner				low = 2.2
3	External Relief Depth		9 H/O		5 H/O				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			9	7	24			

Inspected By (Sign) & Date

Ravi 9/7/24

Satish 9/7/24

Reviewed by (Engineer-CNC)

Manager-QA