



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7858

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.		12400	33/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.2.0.450
3	Pallet Die No.		12746(3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	780	
5	Out Side Diameter	Drg. No.	730 n/c	Step 00, 743.5 n/c
6	Inside Diameter	Drg. No.	630.12 n/c	Tabber 10°
7	Width of Pellet Die	Drg. No.	290 n/c	Slab length 23 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c 15x8x5 n/c	Under cut, 6.75
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of hole = 16 Both Side
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pass: 19/7/24

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°
2	External Relief Dia	3.5 n/c	Outer Side (3-3)		Inner			Pass 42
3	External Relief Depth		23 n/c		17 n/c			
4	Inspection Done Before Hardening By (Name)							Pass:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			19	7	24		

Inspected By (Sign) & Date

Pass: 19/7/24

Reviewed by (Engineer-CNC)

Manager-QA