



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		12427	36/40
3	Pallet Die No.		V.T.L. n/c Shop	Dry hole 2.500
4	Die Category	Drg. No.	11849 (4.0) n/c	See 2.00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 n/c Step ODs 498.8	Tapper 12
7	Width of Pellet Die	Drg. No.	420.12 n/c	Step length 18 n/c
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes 8 Both side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 18.3 n/c	Tapping Depth: 16.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 17/7/24

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	4.5 n/c	outside (2-2)		Inner					See 2.00
3	External Relief Depth		8 n/c		4 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				17	7	24			

Inspected By (Sign) & Date

Ravi 17/7/24

Reviewed by (Engineer-CNC)

Manager-QA