



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10013	34/60
2	Machined By		V.T.L n/c Shop	Drg No. 1.3.02 111
3	Pallet Die No.		10891 (4.0) 44	Reverse
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 44 Step O.D. 792 44	Step length 28.5
6	Inside Diameter	Drg. No.	660.12 44	Under cut 2.8 44
7	Width of Pellet Die	Drg. No.	324 44	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 44 / 21.5 x 8 x 8 44	
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 = 12 Both Side]
12	Tapping PCD		785 44	
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 31.5 44 Tapping Depth 29.8 44	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 7/8/23	
1	As per programme no.		_____	[2 Slot 32.1 44 width 8 44 Deep Both Side]
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		Ravi = 46
2	External Relief Dia	4.8 44	Outside (3-3)	Inner
3	External Relief Depth		30 44	28 44
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 8 23	
Inspected By (Sign) & Date			Ravi 7/8/23	

Reviewed by (Engineer-CNC)

Manager-QA