



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.		12651	40/53
2	Machined By		V.T.L. M/c Shop	Drg No. 1.3.2.9.32
3	Pallet Die No.		12664 (8.0) M/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 M/c Step 00, 384 M/c	Step length 10.8
6	Inside Diameter	Drg. No.	304.12 M/c	
7	Width of Pellet Die	Drg. No.	121 M/c	
8	Grooves as per Drawing	Drg. No.	8.5 x 7 x 2 M/c 8.5 x 7 x 2 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping Holes of holes = 8 Both Side
12	Tapping PCD		350 M/c	
13	Tapping Hole Diameter		M12 = Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 M/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/8/24

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 26.0
2	External Relief Dia	8.5 M/c	Outside 22-29		Inner			Rev 2 8
3	External Relief Depth		17 M/c		13 M/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Formance
6	Material Sent For Hardening On Date		28	8	24			

Inspected By (Sign) & Date

Ravi 22/8/24

Reviewed by (Engineer-CNC)

Manager-QA