



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.		10879	45/50
2	Machined By		V. T. L. H/c Shop	Drg. No. 68.01.0969
3	Pallet Die No.		13372 (4.0) H/c	Revol
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H/c Step OD = 798 H/c	Step length 97 H/c
6	Inside Diameter	Drg. No.	660.12 H/c	Index cot. 16 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21x8x10 H/c / 21x8x10 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 23 Both Side
12	Tapping PCD		725 H/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 = 27.4 H/c	Tapping Depth 95.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/9/24

1	As per programme no.		_____	2 Slot 32 H/c width 9 H/c Deep Both Side
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 1 Hole Closed	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 605

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H/c	Outside (3-3)	Inner					
3	External Relief Depth		13 H/c	5 H/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		20	9	24				

Inspected By (Sign) & Date

Ravi 20/9/24

Reviewed by (Engineer-CNC)

Manager-QA