



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.		12867	42/50
2	Machined By		V. T. L H/c Shop	Dykt, 13.9.74
3	Pallet Die No.		13091(4.0) H/c	Rev: 00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620.1 H/c	Step 00, 623.9 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 1.8 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Width of 1.9 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/9/24

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						Coenter, 60
2	External Relief Dia	4.5 H/c	20 Side (3-3)		Inner			Rev: 32
3	External Relief Depth		12 H/c		8 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Laxman
6	Material Sent For Hardening On Date		18	9	24			

Inspected By (Sign) & Date

Ravi 18/9/24

Reviewed by (Engineer-CNC)

Manager-QA