



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.			
2	Machined By		12953	36/40
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 1.3.02.338
4	Die Category	Drg. No.	12464(3.2)H/C	220202
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/C Step 00, 499 H/C	Tapper 12
7	Width of Pellet Die	Drg. No.	480.12 H/C	Step length 2 H/C
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/C 12x8x3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping dia of holes 8 Both Side
13	Tapping Hole Diameter		454 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 H/C	Tapping Depth 16.5
17	Visual Inspection Before Gun Drilling		Yes OK	

Inspected By (Sign) & Date

Rasi 11/10/24

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	3.5 H/C	Outside 22-25		Inner			Row = 23
3	External Relief Depth		10 H/C		4 H/C			
4	Inspection Done Before Hardening By (Name)							Rao
5	Material Sent For Hardening By (Name)							Lark Porware
6	Material Sent For Hardening On Date			1	10	24		

Inspected By (Sign) & Date

Rasi 11/10/24

11/10/24

Reviewed by (Engineer-CNC)

Manager-QA