



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.		12942	35/40
2	Machined By		V.T.L M/c Shop	Dry Hole 13.0/1157
3	Pallet Die No.		12461 (3.0) H	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H	Step OD: 499.3 H
6	Inside Diameter	Drg. No.	420.12 H	Step length 2.12
7	Width of Pellet Die	Drg. No.	158 H	Step length 2.12
8	Grooves as per Drawing	Drg. No.	12x8x3 H	12x8x3 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping Holes of 4 holes Both Side
12	Tapping PCD		455 H	
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	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30-9-24

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						Counter - 60°
2	External Relief Dia	3.5 H	outside (3.2)	Inner				Row - 24
3	External Relief Depth		10 H	4 H				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		30	09	24			

Inspected By (Sign) & Date

Ravi 30/09/24

Reviewed by (Engineer-CNC)

Manager-QA