



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.		12988	32/50
2	Machined By		V. T.L. H/C Shop	Dy. Insp. 1.2.02 399
3	Pallet Die No.		13433(4.0) H/C	Ravi
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C Step 0.0	500 Tapper 1.0
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 1.8 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		455 H/C	Tapping H/C of Holes 8 Both Side
13	Tapping Hole Diameter		M202 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Ball Depth = 18.4 H/C	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/10/24

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

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/C	Outside (2-2)		Inner				
3	External Relief Depth		18 H/C		12 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			10	10	24			

Inspected By (Sign) & Date

Ravi 10/10/24

Satish 10/10/24

Reviewed by (Engineer-CNC)

Manager-QA