



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8418

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.		13073	
2	Machined By		V.T.L. H/C Shop	29/40, 295
3	Pallet Die No.		12443(3.0) H/C	Dry Holes, look 3310
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	499.9 H/C	Step length 7.5
6	Inside Diameter	Dr. No.	420.12 H/C	
7	Width of Pellet Die	Dr. No.	158 H/C	
8	Grooves as per Drawing	Dr. No.	12x8x3 H/C 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	Tapping Holes of Holes, 8 Both Side
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: 18.4 H/C	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/10/24

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

Count 22 24

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5 H/C	Outside (2-2)	Inner			
3	External Relief Depth		14 H/C	11 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		22	10	24		

Inspected By (Sign) & Date

Ravi 22/10/24

Sets 22/10/24

Reviewed by (Engineer-CNC)

Manager-QA