



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.		13082	53/55
2	Machined By		V.T.C. H/C Shop	Drg No. 150.630
3	Pallet Die No.		13350(3.8) H/C	Res 200
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	530 H/C	Step OD = 491 H/C
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 17.
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	10x10x5 H/C	10x10x5 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 No. of holes: 8 Both Side
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.3 H/C	Tapping Depth: 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/10/24

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
Res = 26

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.3 H/C	Outside (2-2)		Inner		
3	External Relief Depth		9 H/C		2 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		21	10	24		

Inspected By (Sign) & Date

Ravi 21/10/24

Reviewed by (Engineer-CNC)
Satsar 21/10/24

Manager-QA