



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.			
2	Machined By		13496	42/42
3	Pallet Die No.		V.T.L. n/c Shop	Dy. n/c LSP 01/2/12
4	Die Category	Drg. No.	12659 (3.8) n/c	Rev. 1.00
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	389 n/c / Step 00, 386 n/c	Step length 0 n/c
7	Width of Pellet Die	Drg. No.	30512 n/c	
8	Grooves as per Drawing	Drg. No.	126 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	10 x 5 x 4 n/c / 10 x 5 x 4 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of hole = 8 Both Side
13	Tapping Hole Diameter		350 n/c	
14	Tapping On Second Side	Half pitch of 1st side	1/2" & Check by 1/2" Tap	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 15.3 n/c	Tapping Depth = 13.5
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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						Count on Gun
2	External Relief Dia	4.3 n/c	outside (2-25)		Inner			Row 17
3	External Relief Depth		4 n/c		Nil			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Forcare			
6	Material Sent For Hardening On Date		01	12	24			

Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA