



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		13519	36/50
3	Pallet Die No.		N.T.L M/C Shop	Dr. No. 1305369
4	Die Category	Drg. No.	11950 (4.0) M/C	Rev = 00
5	Out Side Diameter	Drg. No.	58870	
6	Inside Diameter	Drg. No.	620 M/C, Step 00, 622.5 M/C	Tappet = 12
7	Width of Pellet Die	Drg. No.	520.12 M/C	Step length 20 M/C
8	Grooves as per Drawing	Drg. No.	190 M/C	Under Part 1.05
9	Fitting Sizes on CNC Plate	Drg. No.	15x5x3 M/C 15x5x3 M/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	Tapping No. of holes = 12 Both side
13	Tapping Hole Diameter		565 M/C	
14	Tapping On Second Side	Half pitch of 1st side	M/C Check by M/C Belt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 25.4 M/C	Tapping Depth: 23.6
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					Counter 60
2	External Relief Dia	4.5 M/C	outside (3-3)		Inner		Ravi 25
3	External Relief Depth		18 M/C		14 M/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		11	12	24		

Inspected By (Sign) & Date

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA