



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.		13191	40/46
2	Machined By		N.T.L n/c Shop	Dy No. 12.0 = 10/11
3	Pallet Die No.		13638(6.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 n/c / Step OD: 384 n/c	Step length 10.4
6	Inside Diameter	Drg. No.	312.12 n/c	
7	Width of Pellet Die	Drg. No.	134 n/c	
8	Grooves as per Drawing	Drg. No.	4x5x3 n/c 4x5x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping w/o of holes = 8 Both Side
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		col 2" = Check by col 2" Plug	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 16.4 n/c Tapping Depth: 14.4 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 7/12/24

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

Counters 60°

1	Counter Sinking Depth & Finish	ok								Low 13
2	External Relief Dia	6.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth		10 n/c		6 n/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		7	12	24					

Inspected By (Sign) & Date

Ravi 7/12/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA