



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.		13238	60/65.5
2	Machined By		V. T. L. n/c Shop	Dy. No. 13.9.93
3	Pallet Die No.		14075(12.0) n/c	Rev. 03
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	639.7 n/c, Step 002 659.2 n/c	Tapper 2.8
6	Inside Diameter	Drg. No.	508.8 n/c (10 Step = 539.7 n/c / 523.3 n/c)	Step length 38 n/c
7	Width of Pellet Die	Drg. No.	175 n/c	
8	Grooves as per Drawing	Drg. No.	30 x 21 x 7.25 n/c 9 x 2.5 n/c	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Step 0.5 n/c
10	Drilling Area Surface Smoothness		ok	Depth
11	Tapping Operator		n/c Shop	Tapping No. of holes 4
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and other side 4 slot	
15	Tapping Hole Depth		Drill Depth = 30.3 n/c Tapping Depth = 28.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/12/24

1	As per programme no.			4 slot
2	Gun Drilling Work Completed On			51.5 n/c long
3	Hole Finish In Gun Drilling	Marked	ok	28.1 n/c wide
4	Defective Holes (If Any)		No	15 n/c Depth

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	12.5 n/c	All Rows					Row = 5
3	External Relief Depth		5.5 n/c					
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark For race
6	Material Sent For Hardening On Date		14	12	24			

Inspected By (Sign) & Date

Ravi 14/12/24

Satyam 14/12/24

Reviewed by (Engineer-CNC)

Manager-QA