



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13528	35/40
2	Machined By		N.T.L. n/c Shop	Drg No. 680-881
3	Pallet Die No.		13118(3-2) n/c	Revised
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 n/c, Step 00.490.7 n/c	
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 16.5
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x5 n/c 12x10x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 8 Both Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		0810" - Check by 0810" Plug	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 n/c - Tapping Depth: 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/24

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 - 1 Hole Colapsed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter: 60° Ravi 26
2	External Relief Dia	3.5 n/c	outside (2-2)		inner			
3	External Relief Depth		8 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porroce
6	Material Sent For Hardening On Date		13	12	24			

Inspected By (Sign) & Date

Ravi 13/12/24

Reviewed by (Engineer-CNC)

Manager-QA