



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

5626

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9716	48/50
2	Machined By		V.T.L. n/c Shop	8752
3	Pallet Die No.		9049(3.5) n/c	1 Day No. Lark SSTO
4	Die Category	Drg. No.	SSTO	
5	Out Side Diameter	Drg. No.	620 n/c	
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 19.5
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	Tapping No. of holes = 12 Both side
13	Tapping Hole Diameter		n/c Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/6/23

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								
2	External Relief Dia	4.0 n/c	outside (3-3)		Inner					Ravi 28
3	External Relief Depth		15 n/c		8 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									10 6 23

Inspected By (Sign) & Date

Ravi 10/6/23

Reviewed by (Engineer-CNC)

Manager-QA