



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.		13678	30/47
2	Machined By		V.T.L. H/c. Shop	Dig No. I.E.C. 15431
3	Pallet Die No.		13680 (B.O) H/c	Rev. 2.00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	613.9 H/c	Step OD = 612 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 30/12/24	
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 - 2 Hole Closed (A)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counters 60° Low 38
2	External Relief Dia	3.5 H/c	outside (3-3)	Inner
3	External Relief Depth		20 H/c	17 H/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		30	12 24
Inspected By (Sign) & Date			Ravi 30/12/24	

Reviewed by (Engineer-CNC)

Manager-QA