



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.		13922	25/45
2	Machined By		V.T.L H/c Shop	Drg No. 1.2.02 1241
3	Pallet Die No.		13141 (-4.3) H/c	Rev 2.00
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	609.8 H/c Step 002 623 H/c	Tapper = 12
6	Inside Diameter	Drg. No.	520.12 H/c	Step length = 17 H/c
7	Width of Pellet Die	Drg. No.	186 H/c	Under cut = 6.6 H/c
8	Grooves as per Drawing	Drg. No.	9x10x3 H/c / 9x10x3 H/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 = 12 Both Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 23.2 H/c	Tapping Depth = 21.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/1/25

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
Ravi = 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.8 H/c	outside (3-3)		Inner		
3	External Relief Depth		24 H/c		20 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		15	1	25		

Inspected By (Sign) & Date

Ravi 15/1/25

Reviewed by (Engineer-CNC)

Manager-QA