



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.		10143	33/40
2	Machined By		V.T.L. n/c Shop	Drg No. L-39874
3	Pallet Die No.		10917 (3.0)mm	Revised
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	385mm Step OD = 383mm	Step length 9.4
6	Inside Diameter	Drg. No.	305.12mm	
7	Width of Pellet Die	Drg. No.	125mm	
8	Grooves as per Drawing	Drg. No.	8x8x3mm 8x8x3mm	
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		350mm	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.6mm Tapping Depth 18-8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/8/23

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								Ravi 19
2	External Relief Dia	3.3mm	outside (2-2)		Inner					
3	External Relief Depth	✓	13mm		7mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			31	8	23				

Inspected By (Sign) & Date

Ravi 31/8/23

Reviewed by (Engineer-CNC)

Manager-QA