



# 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.		10113 to 10162	25/35/66
2	Machined By		V.T.L. N/C Shop	Drg No. 1.S.O. 609
3	Pallet Die No.		10753 (G.O) H	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H Step 002 693 H	Step length 31 H
6	Inside Diameter	Drg. No.	548.12 H	Tapper 8 30.5 H
7	Width of Pellet Die	Drg. No.	194.7 H	Extend cut 2.5 H
8	Grooves as per Drawing	Drg. No.	32.7 x 8 H 31.7 x 7 x 8 H	(4 x 8) H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side step 1.5 H
10	Drilling Area Surface Smoothness		OK	Deep Both sides
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 H	Tapping No
13	Tapping Hole Diameter		N/C Check by N/C Bolt	of holes 4
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth 33.4 H	Tapping Depth 31.7
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

Counter 230

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H / 6.5 H	All Lines						
3	External Relief Depth		41 H			31 H			
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