

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.		9964 to 10269	48/50
2	Machined By		N.T.L. n/c Shop	Dry Run L.R.C. 9980
3	Pallet Die No.		9998 (C.I.C) n/c	Rev 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620.1 n/c Step 002 Tapper 12" Step length 18.5	
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/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 Bottom Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 Check by M20 B.I.	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/9/23

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 5/9/23
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		12 n/c		8 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Romance
6	Material Sent For Hardening On Date			5	9	23			
Inspected By (Sign) & Date		Ravi 5/9/23							

Reviewed by (Engineer-CNC)

Manager-QA