



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.		10174	40/40
2	Machined By		V. T. G. H/c Shop	Drg. No. 9109 Part 550
3	Pallet Die No.		10358 (4.5) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/c Step 00.395 H/c	Step length = 14.5
6	Inside Diameter	Drg. No.	320.12 H/c	
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c / 15.5 x 7 x 2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 8 Beta Side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		NIC; Check by NIC Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/9/23

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 = 15
2	External Relief Dia	4.8 H/c	Outside (2-2)		Inner				
3	External Relief Depth		4 H/c		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		4	9	23				

Inspected By (Sign) & Date

Ravi 4/9/23

Reviewed by (Engineer-CNC)

Manager-QA