



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.		9741	30/40/70
2	Machined By		V.T.C H/C Shop	Drg No. 1-80. 377
3	Pallet Die No.		10478 (G.O) H	Rev=03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 H Step 00. 697.7 H	Tapper 5°
6	Inside Diameter	Drg. No.	548.12 H	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 H	Under cut = 1.8 H
8	Grooves as per Drawing	Drg. No.	29.5x10x8 H / 29.5x10x8 H	6x8 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Pare Side Step 1 H Deep Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 2 Both Side
12	Tapping PCD		618 H	
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 = 32.3 H	Tapping Depth = 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 20/6/23	
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	Counter = 30 Row = 14
2	External Relief Dia	6.5 H / 7.3 H	6.5 H All Lines / 7.3 H All Lines	
3	External Relief Depth		40 H / 30 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		20 6 23	
Inspected By (Sign) & Date			Ravi 20/6/23	

Reviewed by (Engineer-CNC)

Manager-QA