



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)

6307

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10402	40/40
2	Machined By		V.T.L. n/c Shop	
3	Pallet Die No.		10349 (30) n/c	Dy. No. 12.02 7139 Recorol 7137 7139
4	Die Category	Drg. No.	3210	
5	Out Side Diameter	Drg. No.	500 / 3 step 00. 492 n/c	Step length 17
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	104843 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 2 Both Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		Ø3/4" Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.4 n/c Tapping Depth 17.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/10/23

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							
2	External Relief Dia	13.5 n/c	Outside 29-25	Inner					
3	External Relief Depth		6 n/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		23	10	23				
Inspected By (Sign) & Date		Ravi 23/10/23							

Reviewed by (Engineer-CNC)

Manager-QA