



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.			
2	Machined By		10414 ✓	21/65 ✓
3	Pallet Die No.		V.T.L.N/c Shop	Drg No: 1.3.0=698
4	Die Category	Drg. No.	10905 (P.G.O) H4	Rev 200 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo ✓	
6	Inside Diameter	Drg. No.	610 H4 Step OD: 630 H4	630.5 H4 / 549 H4
7	Width of Pellet Die	Drg. No.	480.12 H4	Step length: 19 H4 / 15.5
8	Grooves as per Drawing	Drg. No.	181 H4 ✓	Width cut: 10.9 H4
9	Fitting Sizes on CNC Plate	Drg. No.	25 H4 / 34 H4 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/c Shop	Tapping No of holes: 4
13	Tapping Hole Diameter		538 H4 ✓	
14	Tapping On Second Side	Half pitch of 1st side	MIG 2 Check by MIG Bolt	
15	Tapping Hole Depth		One Side Tapping and 1/2nd Side One Slot	
16	Perpendicularity of Tapped Hole		Drill Depth: 28.4 H4 Tapping Depth: 26.8	
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 26/10/23

1	As per programme no.			2 Slot 29.1 H4 width 14 H4 Deep
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								Row 15
2	External Relief Dia	7.0 H4	All Lines							
3	External Relief Depth		44 H4							
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date									26 10 23

Inspected By (Sign) & Date

Ravi 26/10/23

Reviewed by (Engineer-CNC)

Manager-QA