



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.		10471	45/48
2	Machined By		V.T.C n/c Shop	Drg No. 1-S.D. = 757
3	Pallet Die No.		8826 (3.0) n/c	Rev = 00
4	Die Category	Drg. No.	N/A	
5	Out Side Diameter	Drg. No.	696 n/c Step 00, 703 n/c	Step length = 34
6	Inside Diameter	Drg. No.	600.12 n/c	Tappers = 12°
7	Width of Pellet Die	Drg. No.	265 n/c	Under cot = 3.5 n/c
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c 15x8x7 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 = 16 Both Side
12	Tapping PCD		240 n/c	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 18.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/1/23

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								Row = 46
2	External Relief Dia	3.5 n/c	outside (3-3)		Inner					
3	External Relief Depth	/	9 n/c		3 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Romane
6	Material Sent For Hardening On Date									11/1/23

Inspected By (Sign) & Date

Ravi 11/1/23

Reviewed by (Engineer-CNC)

Manager-QA