



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

6370

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9970	25/35/2.5
2	Machined By		V.T.L. N/C Shop	Dy. No. L.S. 0.857
3	Pallet Die No.		16350 (B.O) 44	Rev 2.00
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	545 44 / 3 step OD = 582 44	502 44
6	Inside Diameter	Drg. No.	420.12 44	Step length = 35 44
7	Width of Pellet Die	Drg. No.	190 44	19 44
8	Grooves as per Drawing	Drg. No.	22x24x8.5 44 / 30x24x8.5 44	
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: 8
12	Tapping PCD		481 44	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side One Slot	
15	Tapping Hole Depth		Drill Depth = 31 44 Tapping Depth = 28.5 44	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/1/23

1	As per programme no.			1 Slot 28.2 44 width 13.5 44 Depth
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							20x211
2	External Relief Dia	6.5 44 / 7.3 44	6.5 44	All Cines	7.3 44	All Cines			
3	External Relief Depth		37.5 44		37.5 44				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		2	11	23				

Inspected By (Sign) & Date

Ravi 21/1/23

Satyam 21/1/23

Reviewed by (Engineer-CNC)

Manager-QA