



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.		10520	53/60
2	Machined By		V.T.L n/c Shop	Drg No. 1.8.0.915
3	Pallet Die No.		11106 (3.8) n/c	Rev. 00
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	64.0 n/c, Step 00 = 615.5 n/c	Tappers 4
6	Inside Diameter	Drg. No.	52.0 n/c	Step length 5 n/c
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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 = 12
12	Tapping PCD		56.5 n/c	Both side
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 2.4 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/11/23	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Low = 33
2	External Relief Dia	4.3 n/c	outside (3-3)	Inner
3	External Relief Depth		14 n/c	7 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4 11 23	
Inspected By (Sign) & Date			Ravi 4/11/23	

Reviewed by (Engineer-CNC)

Manager-QA