



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10530	29/40
2	Machined By		V.T.L. H/C Shop	Dy. No. 1-80-7592
3	Pallet Die No.		10704 (3.0) H/H	Reo 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H Step 002 491 H/H	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x5 H/H / 12x8x5 H/H	
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 Both Side
12	Tapping PCD		455 H/H	
13	Tapping Hole Diameter		φ31.4" - Check by φ31.4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 29.4 H/H Tapping Depth: 29.8 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/11/23	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Ravi 24
2	External Relief Dia	3.5 H/H	20 Side (2-2)	Inner
3	External Relief Depth		14 H/H	11 H/H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6 11 23	
Inspected By (Sign) & Date			Ravi 6/11/23	

Reviewed by (Engineer-CNC)

Manager-QA