



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.		10648	20/40 295
2	Machined By		V.T.L. N/C Shop	Dy. No. Lark SS10
3	Pallet Die No.		10104 (3.0) H/H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500.1 H/H Step OD = 491 H/H Step length = 14.5	
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.	12x8x3 H/H 12x8x3 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		454 H/H	
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 = 18.8 H/H Tapping Depth = 17 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 11/11/23	
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		Low = 24
2	External Relief Dia	3.3 H/H	Outside (2-2)	Inner
3	External Relief Depth		13 H/H	10 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		11	11 23
Inspected By (Sign) & Date			Ravi 11/11/23	

Reviewed by (Engineer-CNC)

Manager-QA