



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.		10661	29/10	
2	Machined By		V.T.L. n/c Step	Dy. No. last 29/10	
3	Pallet Die No.		10709 (3.0) n/c		
4	Die Category	Drg. No.	Senior		
5	Out Side Diameter	Drg. No.	500 n/c Step OD = 491 n/c	Step length 17.5	
6	Inside Diameter	Drg. No.	420.12 n/c		
7	Width of Pellet Die	Drg. No.	158 n/c		
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c 12 x 8 x 3 n/c		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		n/c Step	Tapping No of holes: 8 Back Side	
12	Tapping PCD		454 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: 19.8 n/c	Tapping Depth: 17.5	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 15/11/23		
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		Rev: 24	
2	External Relief Dia	3.5 n/c	outside (2-2)	Inner	
3	External Relief Depth		14 n/c	11 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		15	11	23
Inspected By (Sign) & Date			Ravi 15/11/23		

Reviewed by (Engineer-CNC)

Manager-QA