



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)

6437

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10682	49150/6355
2	Machined By		V.T.L n/a Shop	Dy. M., last 3310
3	Pallet Die No.		10833 (21.0) n/a	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 n/a, Step 002 612 n/a	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 n/a	
7	Width of Pellet Die	Drg. No.	222 n/a	
8	Grooves as per Drawing	Drg. No.	13x8=5 n/a 13x8=5 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		565 n/a	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/a - Tapping Depth 18.8 n/a	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/11/23

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 23
2	External Relief Dia	4.5 n/a	Outside (3-3)		Inner					
3	External Relief Depth		12 n/a		8 n/a					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		17		11		23			

Inspected By (Sign) & Date

Ravi 17/11/23

Reviewed by (Engineer-CNC)

Manager-QA