



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.		10738	40/55
2	Machined By		V.T.L. H/C Shop	Dr. No. 1.85
3	Pallet Die No.		11383(3.5)H	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770H, Step 002 793H	Step length
6	Inside Diameter	Drg. No.	66.12H	
7	Width of Pellet Die	Drg. No.	324H	Undercut = 11.5H
8	Grooves as per Drawing	Drg. No.	21.5x8x12H / 21.5x8x12H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		795H	
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 31.4H	Tapping Depth 29.8H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/23

1	As per programme no.			2 slot 32mm width 8mm Depth Both Side
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 = 52
2	External Relief Dia	4.0H	outside (3-3)		Inner			
3	External Relief Depth		22H		15H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forance
6	Material Sent For Hardening On Date		25	11	23			

Inspected By (Sign) & Date

Ravi 25/11/23

Satyam 25/11/23

Reviewed by (Engineer-CNC)

Manager-QA