



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.		10904 10904	40/66
2	Machined By		V.T.L. H/c Shop	40/66 38/66
3	Pallet Die No.		11183 (2.0) H/c	Order 12.0 = 009
4	Die Category	Drg. No.	H. Jamba	Revol
5	Out Side Diameter	Drg. No.	680.69 H/c Step 002 692.3 H/c	Tapper = 3°
6	Inside Diameter	Drg. No.	548.12 H/c	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c 32 x 7 x 8 H/c (4 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 H/c
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		619 H/c	of Holes = 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.5 H/c Tapping Depth 31.7 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/23

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

Counter = 30

1	Counter Sinking Depth & Finish	ok	Ind Pad All Lines	Ind Pad					Low = 12
2	External Relief Dia	7.0 H/c 7.0 H/c	7.0 H/c All Lines	7.0 H/c All Lines					
3	External Relief Depth		26 H/c	28 H/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		13	12	23				

Inspected By (Sign) & Date
Ravi 13/12/23

Ravi 13/12/23

Reviewed by (Engineer-CNC)

Manager-QA