



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

5746

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		9752	36/50
3	Pallet Die No.		N.T.L. H/c Shop	Drg No. 1.3.D. 505
4	Die Category	Drg. No.	10282 (4.0) H/H	Rev. 00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	730 H/H, Step OD, 743 H/H	Tapper 4°
7	Width of Pellet Die	Drg. No.	630.12 H/H	Step length 27.6 H/H
8	Grooves as per Drawing	Drg. No.	255 H/H	Undercut 6.5 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	22x8x7 H/H 22x8x7 H/H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No of Holes 12 Both Side
13	Tapping Hole Diameter		685 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H22 Check by H22 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 28.4 H/H	Tapping Depth 26.7
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 4/7/23

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					
2	External Relief Dia	4.5 H/H	90° Side (3-3)		Inner		Row-34
3	External Relief Depth		18 H/H		14 H/H		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date						

Inspected By (Sign) & Date

Ravi 4/7/23

Reviewed by (Engineer-CNC)

Manager-QA