



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.		10961	45/60
2	Machined By		V.T.L. n/c shop	Drg No. 180 = 747
3	Pallet Die No.		10913 (A.0) n/c	Rev = 00
4	Die Category	Drg. No.	N. Tomba	
5	Out Side Diameter	Drg. No.	720 n/c, Step OD = 693 n/c	Step length = 20 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 n/c / 12 x 10 x 7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c shop	Tapping No of holes = 12 Both Side
12	Tapping PCD		640 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 = 21 n/c	Tapping Depth = 18.9 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/1/23

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

Counters = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		21 n/c		15 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			4	1	23			

Inspected By (Sign) & Date

Ravi 4/1/23

Satyam
4/1/23

Reviewed by (Engineer-CNC)

Manager-QA