



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.		11038	30/45/55
2	Machined By		V.T.L n/c Shop	Dry No. 1802480
3	Pallet Die No.		11631 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	N. Tombo	
5	Out Side Diameter	Drg. No.	710 n/c, Step OD = 692 n/c	Step length = 19.5
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.	12.5 x 8 x 7 n/c / 12.5 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	Tapping n/c of holes. 12 Both Side
12	Tapping PCD		645 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 = 23 n/c Tapping Depth = 21 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rao: 6/1/24	
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		Counter 260° Rev = 32
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Lines	5.0 n/c All Lines
3	External Relief Depth		25 n/c	10 n/c
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6	1 24
Inspected By (Sign) & Date			Rao: 6/1/24	

Reviewed by (Engineer-CNC)

Manager-QA