



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.			
2	Machined By		11038	22/40
3	Pallet Die No.		V.T.L. n/c Shop	Registers 18.0.01
4	Die Category	Drg. No.	10948 (2.2) n/c	Rev: 01
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 n/c Step 002 498.8 n/c	Tappers 12°
7	Width of Pellet Die	Drg. No.	480.14 n/c	Step length 13
8	Grooves as per Drawing	Drg. No.	158.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes = 8 Both side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	03/4" Check by 03/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 19.8 n/c Tapping Depth: 17.4 n/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 9/1/24

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 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 n/c	outside (2-2)		Inner				Lower 26
3	External Relief Depth		20 n/c		18 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			9	1	24			

Inspected By (Sign) & Date

Ravi 9/1/24

Reviewed by (Engineer-CNC)

Manager-QA