



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)

6748

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11030	32/42/50 ✓
2	Machined By		V. T. L. H/c Shop	Dr. No. 1.3.0.633
3	Pallet Die No.		11388 (4.0) H/H	Rev. 01 ✓
4	Die Category	Drg. No.	58510	✓
5	Out Side Diameter	Drg. No.	619.8 H/H Step 02 = 623.6 H/H	Tappers 12
6	Inside Diameter	Drg. No.	520.14 H/H	Step length 20 H/H
7	Width of Pellet Die	Drg. No.	186 H/H	Under cut 2.9 H/H
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/H	Tapping no
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	of holes = 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Right Side ✓
15	Tapping Hole Depth		Drill Depth = 21.2 H/H	Tapping Depth = 18.8 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/1/24

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

Consider = 60

1	Counter Sinking Depth & Finish	OK								Low = 25
2	External Relief Dia	4.5 H/H 5.0 H/H	4.5 H/H All Lines	5.0 H/H All Lines						
3	External Relief Depth		18 H/H		8 H/H					
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		10	1	24					

Inspected By (Sign) & Date

Ravi 10/1/24

Reviewed by (Engineer-CNC)

Manager-QA