

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.		11101	30/40
2	Machined By		V.T.L. n/c Shop	Dry Holes last 30/40
3	Pallet Die No.		10956 (3.5) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step 002 49 n/c	Step length 17.4
6	Inside Diameter	Drg. No.	480.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c 12 x 8 x 3 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 - 8 Bolt side
12	Tapping PCD		454 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 19.8 n/c Tapping Depth 17 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 15/1/24

1	As per programme no.		
2 ⁿ	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 = 60°
2	External Relief Dia	0.0 n/c	outside (2-2)		Inner		Roz = 22
3	External Relief Depth	✓	14 n/c		10 n/c		
4	Inspection Done Before Hardening By (Name)		✓		Raoi ✓		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		15	1	24		

Inspected By (Sign) & Date

Raoi 15/1/24