



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.		11065	14/65
2	Machined By		V.T.L. N/C Shop	Dr. No. 13.D. 698
3	Pallet Die No.		10898 (3.0) H/H	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	610 H/H / Step OD: 632 H/H	630.5 H/H / 542 H/H
6	Inside Diameter	Drg. No.	480 H/H / 500.1 H/H	Step length: 19 H/H
7	Width of Pellet Die	Drg. No.	181 H/H	15.5 H/H
8	Grooves as per Drawing	Drg. No.	34 H/H / 25 H/H	Undercut 2 1.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	1.1 H/H
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	[Tapping No. of holes: 4]
12	Tapping PCD		538 H/H	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side 2 Slot	
15	Tapping Hole Depth		Drill Depth: 28.4 H/H	Tapping Depth: 26.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/1/24

1	As per programme no.			[2 slot 29 H/H width 14 H/H Depth]
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 4 Holes Colored	

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	3.5 H/H	Outside (3.3)		Inner					
3	External Relief Depth		54 H/H		51 H/H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark For name
6	Material Sent For Hardening On Date		19	1	24					

Inspected By (Sign) & Date

Ravi 19/1/24

Satyam
19/1/24
Reviewed by (Engineer-CNC)

Manager-QA