



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

6839

Inprocess Inspection (Pellet Dies)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11026	53/58
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.0.953
3	Pallet Die No.		11047 (B.8) n/c	Drg. No. 13.0.966
4	Die Category	Drg. No.	Senior	REV 01
5	Out Side Diameter	Drg. No.	536 n/c	Step OD: 494 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Step length: 12.4
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12+8+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 No. of holes = 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		03/4" - Check by 02/4" 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

Ravi 25/1/24

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 - 60
2	External Relief Dia	4.3 n/c	outside 02-23	Inner				low - 21
3	External Relief Depth		12 n/c	5 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Porhace					
6	Material Sent For Hardening On Date		25	1	24			

Inspected By (Sign) & Date
Ravi 25/1/24

Reviewed by (Engineer-CNC)

Manager-QA