



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)

6898

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11041/	36/45
3	Pallet Die No.		V.T.L H/C Step	Drill No. 13.024.09
4	Die Category	Drg. No.	10490 (B.C) H/C	Rev = 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	510.1 H/C, Step 002, 491.1 H/C	Step length 17.4
7	Width of Pellet Die	Drg. No.	420.12 H/C	
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Step	Tapping no of Holes = 8 Both Side
13	Tapping Hole Diameter		454 H/C	
14	Tapping On Second Side	Half pitch of 1st side	023/4" - Check by 023/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.8 H/C	Tapping Depth = 17.2
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 24/1/24

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	0.5 H/C	outside (2-2)	Inner			Low = 15
3	External Relief Depth	/	15 H/C	9 H/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		24	1	24		

Inspected By (Sign) & Date

Ravi 24/1/24

Reviewed by (Engineer-CNC)
Sethi 24/1/24

Manager-QA