



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11192	42/50
3	Pallet Die No.		V.T.L. n/c Shop	Drg. No. 1.2.0.9980
4	Die Category	Drg. No.	11458 (4.0) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	Extrawide	
6	Inside Diameter	Drg. No.	6.901 n/c Step OD: Tapper 12°	Step length 18.5
7	Width of Pellet Die	Drg. No.	5.9012 n/c	
8	Grooves as per Drawing	Drg. No.	2.2.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of 12 Both Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		n/c Shop	
14	Tapping On Second Side	Half pitch of 1st side	12.00 Check by n/c Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 21.3 n/c Tapping Depth: 19 n/c	
17	Visual Inspection Before Gun Drilling		Yes ok	

Inspected By (Sign) & Date

Ravi 23/1/24

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

		Counter Go			
1	Counter Sinking Depth & Finish	ok			20/231
2	External Relief Dia	4.5 n/c	Outside (3-3)	Inner	
3	External Relief Depth		1.2 n/c	8 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Ramace		
6	Material Sent For Hardening On Date		23	1	24

Inspected By (Sign) & Date

Ravi 23/1/24

23/1/24

Reviewed by (Engineer-CNC)

Manager-QA