



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6864

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		11130	38/50
3	Pallet Die No.		V.T.L. n/c Shop	Diagrams 1.8.02 403
4	Die Category	Drg. No.	11700 (4.0) n/c	Rev 2.00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 n/c 3 step 00-49 n/c	3 step length 17.4
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of H.P. 8 Bolt side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	0.3/4" 2 Chacks by 0.3/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.7 n/c	Tapping Depth = 17 n/c
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 29/1/24

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	4.5 n/c	Outside (2-2)		Inner			Rev 2.00
3	External Relief Depth		16 n/c		12 n/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		29	1	24			

Inspected By (Sign) & Date

Ravi 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA