



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

6842

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11094	100/100
2	Machined By		V. T. L. H/c Shop	Drg. No. L.E.C. 17/10
3	Pallet Die No.		11532 (4.0) H/c	Recess
4	Die Category	Drg. No.	Tambo	
5	Out Side Diameter	Drg. No.	830 H/c	Step OD = 743.3 H/c
6	Inside Diameter	Drg. No.	630.12 H/c	Tappers 10°
7	Width of Pellet Die	Drg. No.	265 H/c	Step length = 23
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c / 15x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685 H/c	Tapping Ho of Holes = 16 Both Side
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.0 H/c	Tapping Depth = 19 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/1/24

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 = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia			No	Relief				
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Bhat Natell (Keshav)				
6	Material Sent For Hardening On Date		27	1	24				

Inspected By (Sign) & Date

Ravi 27/1/24

Ravi 27/1/24

Reviewed by (Engineer-CNC)

Manager-QA