



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

6869

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11123	31/40
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.02 865
3	Pallet Die No.		11553 (2.8) n/c	Rev. no
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 n/c, Step 002 383 n/c, 3 step length 11.4	
6	Inside Diameter	Drg. No.	310.12 n/c	
7	Width of Pellet Die	Drg. No.	135 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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		350 n/c	
13	Tapping Hole Diameter		0.31" = Check by 0.31" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4 n/c Tapping Depth = 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		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

Counter 600

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.3 n/c	outside (2-2)		Inner					
3	External Relief Depth		15 n/c		9 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)
Satyam 29/1/24

Manager-QA