



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)

6870

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11185	44/50
3	Pallet Die No.		V.T.L n/a Shop	Dry Hole Lark 3355
4	Die Category	Drg. No.	11606 (4.0) n/a	3310
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	62.0 n/a Step OD = 61.1 n/a Step length = 19.4	
7	Width of Pellet Die	Drg. No.	52.0 n/a	
8	Grooves as per Drawing	Drg. No.	22.0 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/a / 13x8x5 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/a Shop	Tapping n/a of Holes = 12 Both Side
13	Tapping Hole Diameter		56.5 n/a	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.4 n/a Tapping Depth = 18.8	
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 - 1 Hole Closed (P)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Count = 60
2	External Relief Dia	4.5 n/a	Outside (3-3)	Inner				Count = 31
3	External Relief Depth		14 n/a	6 n/a				
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