



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.		9901	40/50
2	Machined By		V.T.L. n/c Shop	Dy. No. L.S.O. 406
3	Pallet Die No.		10008 (4.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 n/c Step 002 622.5 n/c	Tappers 12
6	Inside Diameter	Drg. No.	520.14 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	Order cut 1.25 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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 = 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20x2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 19.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/7/23

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							Rev = 31
2	External Relief Dia	4.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		14 n/c		10 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			14	7	23			

Inspected By (Sign) & Date

Ravi 14/7/23

Reviewed by (Engineer-CNC)

Manager-QA