



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.		9303 to 9907	44/50
2	Machined By		V.T.I. n/c Shop	Drg No. L&C/18780
3	Pallet Die No.		10057 (8.0) n/c	Rec 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Shop OD: 49 n/c	Shop length: 7.4
6	Inside Diameter	Drg. No.	420.12 n/c	(1)
7	Width of Pellet Die	Drg. No.	158 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		454 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.7 n/c	Tapping Depth: 17.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 10/7/23

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

Counter: 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 n/c	outside (2.2)		Innen				
3	External Relief Depth		14 n/c		6 n/c				
4	Inspection Done Before Hardening By (Name)				Raw				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			to	7	23			

Inspected By (Sign) & Date

Raw: 10/7/23

Reviewed by (Engineer-CNC)

Manager-QA