



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

7019

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11338	38/50
2	Machined By		V.T.I. n/a Shop	Dry Hole I.S.O. 978
3	Pallet Die No.		11056 (B.O) n/a	Reo 200
4	Die Category	Dr. No.	3212	
5	Out Side Diameter	Dr. No.	520 n/a	Step length 19.4
6	Inside Diameter	Dr. No.	420.12 n/a	
7	Width of Pellet Die	Dr. No.	182 n/a	
8	Grooves as per Drawing	Dr. No.	12 x 8 x 3 n/a	
9	Fitting Sizes on CNC Plate	Dr. No.	12 x 8 x 3 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		454 n/a	Tapping No. of Holes = 8
13	Tapping Hole Diameter		0314" = Check by 0314" Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 212 n/a Tapping	Depth: 19 n/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/24

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

1	Counter Sinking Depth & Finish	ok					Count = 60
2	External Relief Dia	6.5 n/a	outside (2-2)	inner			Reo 2 18
3	External Relief Depth		16 n/a	12 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		27	2	24		

Inspected By (Sign) & Date

Ravi 27/7/24

Satya 27/7/24

Reviewed by (Engineer-CNC)

Manager-QA