



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.		11422	38/36
2	Machined By		V. T. L. H/c Shop	Dry size 1.2.02 756
3	Pallet Die No.		10993 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	492 H/c, Step 002 = 491 H/c, Step length 16.9	
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	104/104.5 H/c / 104/104.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/c	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c Tapping Depth 17.8	
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	Counter. 60° Rev = 30
2	External Relief Dia		3.5 H/c	Outside (2.2)
3	External Relief Depth		4 H/c	Inner Mill
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	28
Inspected By (Sign) & Date			Ravi 27/7/24	

Reviewed by (Engineer-CNC)

Manager-QA