



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.		9943	33/40
2	Machined By		V.T.L. H/c Shop	Drg No. L.S.D.-177
3	Pallet Die No.		10332 (3.0) H/H	Rev 2.00
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	500 H/H - Step OD	Tapping 12° Step length 17.7
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	182 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x4 H/H 13x8x4 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of holes = 8 Both Side
12	Tapping PCD		455 H/H	
13	Tapping Hole Diameter		ø314" = Check by ø314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 28.4 H/H	Tapping Depth 19.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/7/23

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 2.29
2	External Relief Dia	3.5 H/H	outside (2-2)			Inner						
3	External Relief Depth		13 H/H			7 H/H						
4	Inspection Done Before Hardening By (Name)											
5	Material Sent For Hardening By (Name)											Lark Furnace
6	Material Sent For Hardening On Date											15 7 23

Inspected By (Sign) & Date

Ravi 15/7/23

Reviewed by (Engineer-CNC)

Manager-QA

Tanuj 15/7/22