



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.		11311	30/35/79
2	Machined By		V. T. C. H/C Shop	Drg No. 12.9.77
3	Pallet Die No.		11789 (6.0) H	Rev. 01
4	Die Category	Drg. No.	S. Jamba	
5	Out Side Diameter	Drg. No.	1008 H, Step 002 1023 H	Tappes = 8°
6	Inside Diameter	Drg. No.	850.12 H	Step length 41 H
7	Width of Pellet Die	Drg. No.	266 H	Under Cut 2.44
8	Grooves as per Drawing	Drg. No.	45x8x10 H / 45x8x10 H	
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 2 Back Side
12	Tapping PCD		935 H	
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 48.6 H Tapping Depth 60 H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 29/7/24	
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 Bore Rops 16
2	External Relief Dia	6.5 H / 7.3 H	6.5 H All Rows	7.3 H All Rows
3	External Relief Depth	/	49 H	44 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		29	29
Inspected By (Sign) & Date			Ravi 29/7/24	

Reviewed by (Engineer-CNC)

Manager-QA