



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11379	40/45
2	Machined By		N.T.L. n/c Shop	Drg No. 13.02.492
3	Pallet Die No.		11136 (4.5) n/c	Rev. 00
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	510 n/c, Step 002 491 n/c	Step length = 7.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12+8+3 n/c 12+8+3 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		n/c? Check by H24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19 n/c	Tapping Depth = 17 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 1/12/24	
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 Sink Rev. 22	
2	External Relief Dia	5.0 n/c	Outside (2-2)	Inner
3	External Relief Depth		9 n/c	5 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For more	
6	Material Sent For Hardening On Date		1	3 24
Inspected By (Sign) & Date			Ravi 1/12/24	

Reviewed by (Engineer-CNC)

Manager-QA