



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.		11401	40/50
2	Machined By		V.T.L H/c Shop	Drg. No. 13.02.405
3	Pallet Die No.		11930 (2.5) H/c	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/c, Step 00 = 499 H/c	Tapper 12
6	Inside Diameter	Drg. No.	420.12 H/c	Step length = 17 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
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		454 H/c	
13	Tapping Hole Diameter		03/16" = Check by 03/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 19 H/c Tapping Depth. 17 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/3/24

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

Counter G^o

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H/c	Outside (2-2)		Inner				
3	External Relief Depth		17 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		9	3	24				

Inspected By (Sign) & Date

Ravi 9/3/24

Satyam 9/3/24

Reviewed by (Engineer-CNC)

Manager-QA