



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.		11377	44/51
2	Machined By		V.T.C. H/c Shop	Dry No. 1.8.2976
3	Pallet Die No.		11710(6.0) H/H	Rev 2 <u>OK</u>
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/H, Step 00.492 H/H	Step length 13.4 H/H
6	Inside Diameter	Drg. No.	420.12 H/H, Boss 418.1 H/H	
7	Width of Pellet Die	Drg. No.	152.1 H/H	
8	Grooves as per Drawing	Drg. No.	1175x3 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		456 H/H	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.8 H/H	Tapping Depth 15 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/3/24

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

1	Counter Sinking Depth & Finish	OK						Counters 60° Ravi 15
2	External Relief Dia	6.5 H/H	outside (2-2)		Inner			
3	External Relief Depth		13 H/H		7 H/H			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			8	3	24		

Inspected By (Sign) & Date

Ravi 28/3/24

Satyam 28/3/24

Reviewed by (Engineer-CNC)

Manager-QA