



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)

7032

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11313	55/55
2	Machined By		V.T.L. H/c Shop	Dry Hole L&C. 14/24
3	Pallet Die No.		11355 (4.0) H/c	Rev 2.00
4	Die Category	Drg. No.	End outside	
5	Out Side Diameter	Drg. No.	630 H/c Step 002 G12 H/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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 12 Both Side
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		M2x2 Check by M2x2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.2 H/c Tapping Depth 18.8 H/c	
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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/c	2 side 3-2		Inner					
3	External Relief Depth		5 H/c		Mill					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Ramesh					
6	Material Sent For Hardening On Date				29	2	24			

Inspected By (Sign) & Date

Ravi 29/7/24

Satish 29/7/24

Reviewed by (Engineer-CNC)

Manager-QA