



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.		11405	36/45
2	Machined By		V.T.L. H/c Shop	Drilling U.S.O. Rod
3	Pallet Die No.		11137 (G.O) H/c	Rev. 00
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	510 H/c, Step 002 491 H/c	Step length 18.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	1048.5 x 5 H/c / 1048.5 x 5 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		455 H/c	
13	Tapping Hole Diameter		0.314" 2 Check by 0.314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.6 H/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/3/24

- As per programme no.
- Gun Drilling Work Completed On
- Hole Finish In Gun Drilling
- Defective Holes (If Any)

Marked

OK

No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter: 600

1	Counter Sinking Depth & Finish	OK								Ravi 12/3/24
2	External Relief Dia	6.5 H/c	Outside 2-2	Inner						
3	External Relief Depth		15 H/c	9 H/c						
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Romare
6	Material Sent For Hardening On Date		12	3	24					

Inspected By (Sign) & Date

Ravi 12/3/24

Reviewed by (Engineer-CNC)

Manager-QA