



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11478	45/45
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.S.O. 06
3	Pallet Die No.		11141 (8.0) n/c	Rev. 01
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	510 n/c Step 002 491 n/c	Step length 17
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.	10x10x5 n/c 10x10x5 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		455 n/c	
13	Tapping Hole Diameter		0.314" - Check by 0.314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c Tapping Depth 17.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/3/24

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					Counter 60°
2	External Relief Dia	0.5 n/c	Outside (2-2)		Inner		Case 15
3	External Relief Depth		4 n/c		Null		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		12	3	24		

Inspected By (Sign) & Date

Ravi 12/3/24

Reviewed by (Engineer-CNC)

Manager-QA