



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.		11449	35/40
2	Machined By		V.T.L. M/C Shop	9195 Dy. M/c Labk 9310
3	Pallet Die No.		10974 (3-2) M	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 M, Step on 491 M, Step length 12.4	
6	Inside Diameter	Drg. No.	420.12 M	
7	Width of Pellet Die	Drg. No.	158 M	
8	Grooves as per Drawing	Drg. No.	12x8x3 M 12x8x3 M	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454 M	
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.3 M, Tapping Depth = 16.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/3/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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, Go
2	External Relief Dia	2.5 M	outside (2-2)	Inner					Rep = 23
3	External Relief Depth		11 M	5 M					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		19	23	24				

Inspected By (Sign) & Date

Ravi 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA