

7/07



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.		11400	33140
2	Machined By		V. T. L. n/c Shop	Drilled Lark 3312
3	Pallet Die No.		11592 (3.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 n/c, Step OD = 395 n/c	Step length = 14.4
6	Inside Diameter	Drg. No.	320.12 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c / 15.5 x 7 x 2 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		355 n/c	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 n/c Tapping Depth = 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/3/24

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

Counters 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5 n/c	Outside (3-2)		Inner			
3	External Relief Depth		13 n/c		7 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		14	3	24			

Inspected By (Sign) & Date

Ravi 14/3/24

Reviewed by (Engineer-CNC)
14/3/24

Manager-QA