



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7114 ~~2039~~

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.		11491 ✓	32/39 ✓
2	Machined By		V.T.L. H/c Shop	Dry Hole L&G 1001
3	Pallet Die No.		12081 (3.0) H/H	Rev 200
4	Die Category	Drg. No.	2-dia wide	
5	Out Side Diameter	Drg. No.	598 H/H, Step 002 G18 H/H	Step length 20mm
6	Inside Diameter	Drg. No.	520.14 H/H	Undercut 7mm
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping Hole of Holes - 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/H	Tapping Depth 18.8 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/3/24

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	3.3 H/H	AI	Rows				Row 38
3	External Relief Depth			7 H/H				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Forware				
6	Material Sent For Hardening On Date		15	3	24			

Inspected By (Sign) & Date

Ravi 15/3/24

Satyam 15/3/24

Reviewed by (Engineer-CNC)

Manager-QA