



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.		11499	39/50
2	Machined By		V.T.L. H/c Shop	Drilling (30.998)
3	Pallet Die No.		11955 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step 00. Tapper 12° Step length 18.5
6	Inside Diameter	Drg. No.	5.20 H/c	
7	Width of Pellet Die	Drg. No.	2.2 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes 12 Both Side
12	Tapping PCD		5.65 H/c	
13	Tapping Hole Diameter		H/c. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/1/24

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/c	Outside (3.3)	Inner			Rev. 38
3	External Relief Depth		1.7 H/c	1.1 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		15	3	24		
Inspected By (Sign) & Date		Ravi 15/3/24					

Sats 15/3/24

Reviewed by (Engineer-CNC)

Manager-QA