



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

7148

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11516	35/45
2	Machined By		V.T.L. H/c Shop	Drg. No. 18.02.433
3	Pallet Die No.		11139 (5.0) H/c	Rev. No.
4	Die Category	Drg. No.	3812	
5	Out Side Diameter	Drg. No.	510 H/c Step 002 491 H/c	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182.1 H/c (5)	
8	Grooves as per Drawing	Drg. No.	12x8 x 3 H/c / 12x8 x 3	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping N of Holes 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8 H/c	Tapping Depth 17.0 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/3/24

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 Sink
2	External Relief Dia	5.5 H/c	Outside (2-2)	Inner				
3	External Relief Depth		15 H/c	long				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ponnace
6	Material Sent For Hardening On Date		30	3	24			
Inspected By (Sign) & Date		Ravi 30/3/24						

Reviewed by (Engineer-CNC)

Manager-QA