



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.		11507	39/40
2	Machined By		V. T. I. H/C Shop	Drg No. 11694 (3.5) H/C
3	Pallet Die No.		11694 (3.5) H/C	
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD = 491 H/C	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C 12x8x3 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 - 8 Both Side]
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 H/C Tapping Depth 17.2 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 27/3/24	
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 - 1 Hole Closed (A)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Ravi 27
2	External Relief Dia	4.0 H/C	outside (2-2)	
3	External Relief Depth		12 H/C	Inner 8 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		27	3 24
Inspected By (Sign) & Date			Ravi 27/3/24	

Reviewed by (Engineer-CNC)

Manager-QA