



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.		11317	45/60
2	Machined By		V.T.L n/c Shop	Dr H20 12.02 584
3	Pallet Die No.		12231 (80) n/c	Rev 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c Step 00 = 798 n/c Tapper = 4	
6	Inside Diameter	Drg. No.	660.12 n/c	Step length = 25.5
7	Width of Pellet Die	Drg. No.	324 n/c	Udr cut = 9 n/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 n/c 21.5 x 8 x 10 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Ho of Holes = 12 Both Side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.8 n/c Tapping Depth = 28.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 28/3/24	2 Slot 32.1 n/c width 8 n/c Deep Both Side
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 Go
2	External Relief Dia		8.5 n/c	
3	External Relief Depth		003 side (2-3) 23 n/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		28 3 24	
Inspected By (Sign) & Date			Ravi 28/3/24	

Reviewed by (Engineer-CNC)

Manager-QA