



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.		11508	28/40
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.2.02 335
3	Pallet Die No.		11289 (3.5) H/C	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step 02, 491 H/C	Step Length 174
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158.2 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		N/C Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		0314" Check by 0314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H/C	Tapping Depth 17.4 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pass: 28/3/24

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							Counter 60
2	External Relief Dia	2.8 H/C	Outside (2-2)		Inner				
3	External Relief Depth		8 H/C		2 H/C				
4	Inspection Done Before Hardening By (Name)								Soni
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		28	3	24				

Inspected By (Sign) & Date

Pass: 28/3/24

Reviewed by (Engineer-CNC)

Manager-QA