



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.		11538	42/45
2	Machined By		V.T.L. H/c Shop	Dy No. 1.5.92541
3	Pallet Die No.		11799 (3.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410.2 H/c, Step 002 395mm Step length 14.5	
6	Inside Diameter	Drg. No.	320.12 H/c	
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.577 x 2 H/c 15.577 x 2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping Area of holes - 8 Both Side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		M16 - Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 H/c Tapping Depth 18.5 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/3/24

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					Count etc. 60
2	External Relief Dia	3.5 H/c	outside (2-2)	Inner			
3	External Relief Depth		9 H/c	3 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		29	3	24		
Inspected By (Sign) & Date			Ravi 29/3/24				

Reviewed by (Engineer-CNC)

Manager-QA