



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.		9450 to 11616	35/40
2	Machined By		V. T.O. H/c Shop	Drilling Hole Size 15-62
3	Pallet Die No.		9763 (5.0) H/c	Revs 50
4	Die Category	Drg. No.	Senior	Drilling Size 13.95
5	Out Side Diameter	Drg. No.	500 H/c Step 00. 498.38	Tappet 12"
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 8 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/c / 12+8+3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 2 Back side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H/c	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/8/24

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 02-25	Inner			Row 2 12
3	External Relief Depth		10 H/c	5 H/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Purpore
6	Material Sent For Hardening On Date		20	3	24		

Inspected By (Sign) & Date

Ravi 20/8/24

Reviewed by (Engineer-CNC)

Manager-QA