



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.		11638	35/40
2	Machined By		V.T.L. H/c Shop	Drg No. 13.2881
3	Pallet Die No.		18328(3.2) H/c	Rev 2.00
4	Die Category	Drg. No.	SE10	
5	Out Side Diameter	Drg. No.	500 H/c Step OD. 490.7 H/c	Step length 16.5
6	Inside Diameter	Drg. No.	420.14 H/c	
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	10x12x5 H/c 10x12x5 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 8 Both Side
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.8 H/c Tapping Depth. 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/24

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
2	External Relief Dia	3.8 H/c	outside (2.2)		Inner			Ravi 31/7/24
3	External Relief Depth		8 H/c		5 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		3	4	24			
Inspected By (Sign) & Date		Ravi 31/7/24						

Reviewed by (Engineer-CNC)

Manager-QA