



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

7254

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11577	50/55
2	Machined By		V.T.L H/c Shop	Dy. No. 13.0.355
3	Pallet Die No.		11088(4.0)H	Row 2.05
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	630H / Step 00, 612H / Step length 20H	
6	Inside Diameter	Drg. No.	520.14H	
7	Width of Pellet Die	Drg. No.	186H	
8	Grooves as per Drawing	Drg. No.	13x8x3H / 13x8x3H	
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. 12 Both Side
12	Tapping PCD		565H	
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. 20.7H Tapping Depth = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/4/24

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 = 60 Row = 25
2	External Relief Dia	4.5H	outside (3-3)	Inner			
3	External Relief Depth		13H	5H			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		4	4	24		

Inspected By (Sign) & Date

Ravi 4/4/24

Seta 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA