



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5605

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9833	30/50
2	Machined By		N.T.L H/O Shop	Drg No. L.S.D. 245
3	Pallet Die No.		10206 (3.0) H	Rev 2.01
4	Die Category	Drg. No.	H. Tamba	
5	Out Side Diameter	Drg. No.	700 H, Step OD = 693 H	Step length 19.8
6	Inside Diameter	Drg. No.	600.12 H	(A)
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	1448 x 7 H / 1448 x 7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/O Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		640 H	
13	Tapping Hole Diameter		H20	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5 H	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 3/6/23	
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		Ravi 37
2	External Relief Dia	3.5 H	Outside (3-3)	Inner
3	External Relief Depth		25 H	20 H
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	6 23
Inspected By (Sign) & Date			Ravi 3/6/23	

Reviewed by (Engineer-CNC)

Manager-QA