



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)

7300

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11727	98/40
2	Machined By		V.T.L H/c Shop	Dy No. 1.802 5062
3	Pallet Die No.		11291 (3-5) H/c	Rev = 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Step 002 498.8 H/c	Tapper 12"
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	158.2 H/c	
8	Grooves as per Drawing	Drg. No.	11.7 x 8 x 3 H/c / 11.8 x 8 x 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 H/c of Holes 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8 H/c Tapping Depth 17 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/4/24

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter 60
2	External Relief Dia	3.8 H/c	Opp Side (2-2)	Inner				Rev = 22
3	External Relief Depth		15 H/c	12 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		11	4	24			

Inspected By (Sign) & Date

Ravi 11/4/24

Reviewed by (Engineer-CNC)

Manager-QA