



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.		11523/	120/120
2	Machined By		V.T.L n/c Shop	Qty 120 559
3	Pallet Die No.		10033 (3.0) n/c	Recd
4	Die Category	Drg. No.	Turn bar	
5	Out Side Diameter	Drg. No.	870 n/c, Step 002 743.0 n/c	Tapping 15°
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 28 n/c
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping 15°
12	Tapping PCD		685 n/c	of holes 16
13	Tapping Hole Diameter		H20 - Check by H20 Balls	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 18/4/24	
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 = 25 Hole Coloced	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	_____	Counter = 60 Sasi = 44
2	External Relief Dia	_____	No = Reliy	
3	External Relief Depth	_____	_____	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Keshav	
6	Material Sent For Hardening On Date		18 4 24	
Inspected By (Sign) & Date			Sasi 18/4/24	

Sasi 18/4/24

Reviewed by (Engineer-CNC)

Manager-QA