



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.		9924	29/50
2	Machined By		V. T. L. n/c Shop	Drg. No. Lark 8752
3	Pallet Die No.		9059 (3.2) n/c	
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	619.5 n/c (1) Step 002 611.5 n/c	Step length 19.4 (1)
6	Inside Diameter	Drg. No.	580.12 n/c	
7	Width of Pellet Die	Drg. No.	185.7 n/c (1)	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 12.7x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - 2 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/23

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							Rep = 29
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		Gun		21 n/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		21	7	23				

Inspected By (Sign) & Date

Ravi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA