



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.			
2	Machined By		11928	11/10
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 1.3.0.905
4	Die Category	Drg. No.	11815(D.8)-H	Revised
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/c Step 002 491 H/c	Step length = 7.5
7	Width of Pellet Die	Drg. No.	4.20-1.2 H/c	
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping H/c of holes = 8 Both side
13	Tapping Hole Diameter		454 H/c	
14	Tapping On Second Side	Half pitch of 1st side	0314" - Check by 0314" Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth: 19.8 H/c Tapping Depth: 17.3 H/c	
17	Visual Inspection Before Gun Drilling		Yes OK	

Inspected By (Sign) & Date

Ravi 18/5/24

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°
2	External Relief Dia	3.5 H/c	outside (2-2)	Inner			Pass 26
3	External Relief Depth		3 H/c	Mill			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Purware
6	Material Sent For Hardening On Date		18	5	24		

Inspected By (Sign) & Date

Ravi 18/5/24

Satyam 18/5/24

Reviewed by (Engineer-CNC)

Manager-QA