



Lark Engineering Company (India) Pvt. Ltd.

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

1689

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		12170	36/45
3	Pallet Die No.		N/A n/c Shop	Dr. Holes 18.0 to 70
4	Die Category	Drg. No.	12239(4.0) n/c	Reverse
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	395 n/c Step 00, 386 n/c Step length 11.5	
7	Width of Pellet Die	Drg. No.	305.12 n/c	
8	Grooves as per Drawing	Drg. No.	144 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	16x8x5 n/c 16x8x5 n/c	
10	Drilling Area Surface Smoothness	Drg. No.	OK	
11	Tapping Operator		n/c Shop	Tapping Holes of Hole B Both Side
12	Tapping PCD		353 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/c Tapping Depth 18.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/6/24

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

Count on 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	U.5 n/c	Outside (2-2)		Inner				
3	External Relief Depth		13 n/c		9 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Fornare				
6	Material Sent For Hardening On Date		18	6	24				

Inspected By (Sign) & Date

Ravi 18/6/24

Satyam 18/6/24

Reviewed by (Engineer-CNC)

Manager-QA