



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.		9866	32/42/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.80-633
3	Pallet Die No.		9063 (4.0) n/c	Rev 2.91
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	62 n/c Step 002 623.6 n/c	Step length 20 n/c
6	Inside Diameter	Drg. No.	52.14 n/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	186 n/c	Width cut 2.8 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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		56.5 n/c	
13	Tapping Hole Diameter		NICE Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/7/23	
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		Rev 2.25
2	External Relief Dia	4.5 n/c 5.0 n/c	4.5 n/c All Lines	5.0 n/c All Lines
3	External Relief Depth		18 n/c	8 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		4 7 23	
Inspected By (Sign) & Date			Ravi 4/7/23	

Reviewed by (Engineer-CNC)

Manager-QA