



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.		9793	45/45 ✓
2	Machined By		V.T.L. H/c Shop	By No. 18.D.2840
3	Pallet Die No.		9125 (3.5) H/c	Recessed
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 H/c ✓	Tap length 12
6	Inside Diameter	Drg. No.	420.12 H/c ✓	Step length 19.5
7	Width of Pellet Die	Drg. No.	154 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x10x5 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12.4x10x5 H/c ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c ✓	Tapping No of holes: 8
13	Tapping Hole Diameter		M20 ✓	Both Side
14	Tapping On Second Side	Half pitch of 1st side	Check by M20 Bolt ✓	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth: 17.5 H/c ✓	Tapping Depth: 15.8 ✓
17	Visual Inspection Before Gun Drilling		Yes OK	
Inspected By (Sign) & Date			Ravi 5/7/23	
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 2.2
2	External Relief Dia	4.0 H/c	Outside 2-3	
3	External Relief Depth		4 H/c	
4	Inspection Done Before Hardening By (Name)		Inner Nil	
5	Material Sent For Hardening By (Name)		Ravi	
6	Material Sent For Hardening On Date		Lark Furnace	
Inspected By (Sign) & Date			5 7 23	
Inspected By (Sign) & Date			Ravi 5/7/23	Tanuj 5/7/23

Reviewed by (Engineer-CNC)

Manager-QA