



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.		9860	44/50
2	Machined By		V.T.L. H/O Shop	Drg No. I.S.O. 8752
3	Pallet Die No.		9057 (4.0) H/O	
4	Die Category	Drg. No.	38872	
5	Out Side Diameter	Drg. No.	620 H/O Step 002 311.9 H/O Step length 19.4	
6	Inside Diameter	Drg. No.	520.12 H/O	
7	Width of Pellet Die	Drg. No.	186 H/O	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/O / 13x8x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	[Tapping No of Holes = 12 Both Side]
12	Tapping PCD		565 H/O	
13	Tapping Hole Diameter		H20 = Check by H2-Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Report: 20.4 H/O Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		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		Low = 25
2	External Relief Dia	4.5 H/O	Outside (3-3)	Inner
3	External Relief Depth		14 H/O	6 H/O
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 7 23	
Inspected By (Sign) & Date			Ravi 5/7/23	

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Reviewed by (Engineer-CNC)

Manager-QA

Tarun Singh
5/7/23