



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.		11014	415/60
2	Machined By		V.T.L. H/c Shop	Dry No. 1-2-2-584
3	Pallet Die No.		11002 (11002)	Reused
4	Die Category	Drg. No.	7umbo	
5	Out Side Diameter	Drg. No.	780mm, Step 002 797.6mm	Tapping 40
6	Inside Diameter	Drg. No.	660.12 mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 mm	Under cut 2.8mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm 21.5 x 8 x 10 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 12
12	Tapping PCD		725 mm	Both Side
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 31.4 mm	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/1/24	
1	As per programme no.			2 slot
2	Gun Drilling Work Completed On			32.1 mm width
3	Hole Finish In Gun Drilling	Marked	ok	2 mm Deep
4	Defective Holes (If Any)		No	Both Side
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	8.5 mm	Outside (2.3)	Inner
3	External Relief Depth		23 mm	15 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		24	1
Inspected By (Sign) & Date			Ravi 24/1/24	

Manager-QA