

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.		9802	39/50
2	Machined By		N.T.L. n/c Shop	8751 8319
3	Pallet Die No.		9050 (3.5) n/c	
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	620 n/c Step 02 611.9 n/c Stepleng 11.9 n/c	
6	Inside Diameter	Drg. No.	520.14 n/c / 520.2 n/c	
7	Width of Pellet Die	Drg. No.	186 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	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		N202 Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 n/c	Tapping Depth 18.9
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/7/23

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 - 1 Hole Closed (B)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	3.8 n/c	Outside (3-3.9)		Inner					
3	External Relief Depth		18 n/c		11 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		6	7	23					

Inspected By (Sign) & Date

Ravi 6/7/23

Reviewed by (Engineer-CNC)

Manager-QA