



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.		10295	35/40
2	Machined By		V.T.L. n/c Shop	Dy. No. 1-2-9-281
3	Pallet Die No.		12731 (3.2) ny	Rev 200
4	Die Category	Drg. No.	500	
5	Out Side Diameter	Drg. No.	500 ny Step 00.490.7 ny	Step length 18.5
6	Inside Diameter	Drg. No.	420.12 ny	
7	Width of Pellet Die	Drg. No.	173 ny	
8	Grooves as per Drawing	Drg. No.	12x10x5 ny 12x10x5 ny	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455 ny	Tapping H. of hole 8 Bolt Side
13	Tapping Hole Diameter		0.314" = Check by 0.314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 ny	Tapping Depth: 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/2/24

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						Counter, B...
2	External Relief Dia	3.5 ny	outside (2.2)		inner			Ravi 26
3	External Relief Depth		8 ny		5 ny			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		9	7	24			

Inspected By (Sign) & Date

Ravi 9/2/24

Satya 9/2/24

Reviewed by (Engineer-CNC)

Manager-QA