



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12409	92/40
2	Machined By		N.T.L. n/c Shop	Drg No. 1.8.2011
3	Pallet Die No.		9497 (D.B) mm	Res. of
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step 002 499 mm	Tappes 12
6	Inside Diameter	Drg. No.	420.12 mm	Step length 15 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping of hole of hole 8 Back Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/7/24	
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 6 Row 2 26
2	External Relief Dia	3.3 mm	Outside (2-2)	Inner
3	External Relief Depth		20 mm	18 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		19	7
Inspected By (Sign) & Date			Ravi 19/7/24	

Reviewed by (Engineer-CNC)
20/7/24

Manager-QA