



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.		9411 to 9735	38/50
2	Machined By		V. T. G. n/c Shop	Drg. No. 10156 (3.0) 980
3	Pallet Die No.		10156 (3.0) 44	(Rev. 00)
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	680 n/c Step OD ₂ Tapper 12° Step length 18	
6	Inside Diameter	Drg. No.	520.12 44	
7	Width of Pellet Die	Drg. No.	288 44	
8	Grooves as per Drawing	Drg. No.	13x8x5 44 13x8x5 44	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 44	
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 80.5 44 Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 6/6/23

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						Per = 38
2	External Relief Dia	3.5 44	outside (3-3)		Inner			
3	External Relief Depth		18 44		12 44			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		6	6	25			

Inspected By (Sign) & Date

Raw: 6/6/23

Reviewed by (Engineer-CNC)

Manager-QA