



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.		10009	36/40
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.O. 495
3	Pallet Die No.		10333 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 n/c Step OD = 492 n/c	Step length 16.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 n/c 10x8.5x5 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		455 n/c	Tapping No of holes: 8 Beta side
13	Tapping Hole Diameter		Ø34" = Check by 32/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.6 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/8/23

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						
2	External Relief Dia	3.3 n/c	Outside (2-2)		Inner			Low 2.88
3	External Relief Depth		10 n/c		4 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Ravi 21/8/23

Reviewed by (Engineer-CNC)

Manager-QA