



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.		10135	33/50	
2	Machined By		V.T.L. n/c Shop	Drg No: L.P.O. 103	
3	Pallet Die No.		8820 (3.0) n/c	Rev 201	
4	Die Category	Drg. No.	NJEW		
5	Out Side Diameter	Drg. No.	700 n/c Step OD: 699 n/c	Step length: 19.5	
6	Inside Diameter	Drg. No.	600.12 n/c		
7	Width of Pellet Die	Drg. No.	265 n/c		
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c 15x8x7 n/c		
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: 16 Both Side	
12	Tapping PCD		640 n/c		
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: 20.4 n/c Tapping Depth: 18.8		
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi: 22/8/23	2 Slot 39.1 n/c width 8 n/c Deep Both Side	
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		Rev: 47	
2	External Relief Dia	3.5 n/c	Outside (3-3)		
3	External Relief Depth	✓	93 n/c	Inner 17 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		22	8	23
Inspected By (Sign) & Date			Ravi: 22/8/23		

Reviewed by (Engineer-CNC)

Manager-QA