



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.		10100	38150
2	Machined By		V.T.L n/c Shop	Dry No. I.S.O. 322
3	Pallet Die No.		10878 (4.0) n/c	Row 20
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Step 00. From Tapper 10	
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 18
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 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 8 Roh Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		M20x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 n/c Tapping Depth 16.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi: 23/8/23

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 - Hole Colored (0)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Row 20
2	External Relief Dia	4.5 n/c	outside (2-2)		Inner				
3	External Relief Depth	✓	16 n/c		12 n/c				
4	Inspection Done Before Hardening By (Name)		Rasi:						
5	Material Sent For Hardening By (Name)		Lark Porrace						
6	Material Sent For Hardening On Date		23	8	23				

Inspected By (Sign) & Date

Rasi: 23/8/23

Reviewed by (Engineer-CNC)

Manager-QA