



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.		13348	LSR - 1203 Rev 00
2	Machined By		V.T.L. n/c Shop	
3	Pallet Die No.		13365 (4.0) n/c	75/78
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	680mm Step 00, 682	44/78 Step length, 97
6	Inside Diameter	Drg. No.	530.12 mm	When cot 1 mm 17.5
7	Width of Pellet Die	Drg. No.	278 mm	
8	Grooves as per Drawing	Drg. No.	278 x 8 x 8 mm 43 x 8 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	✓
10	Drilling Area Surface Smoothness		ok	Tapping No. of holes, 8
11	Tapping Operator		n/c Shop	
12	Tapping PCD		594 mm	
13	Tapping Hole Diameter		MIS Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side One Slot	
15	Tapping Hole Depth		Drill Depth, 25.4 mm	Tapping Depth, 23.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 26/11/24	1910t
1	As per programme no.		_____	29.1 mm width 18 mm Reep ✓
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 1 Hole Closed (10)	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Rev = 34
2	External Relief Dia	—	—	No - Reting
3	External Relief Depth	—	—	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porware	
6	Material Sent For Hardening On Date		26 11 24	
Inspected By (Sign) & Date			Ravi 26/11/24	

Reviewed by (Engineer-CNC)

Manager-QA