



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.		10040	35/40
2	Machined By		V.T.L. n/c Shop	Dy No. L.S.D.-865
3	Pallet Die No.		10856 (4.0) n/c	Rev 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	39.0 n/c	Step 0.0, 38.3 n/c
6	Inside Diameter	Drg. No.	31.12 n/c	Step length 11.4
7	Width of Pellet Die	Drg. No.	135.1 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 Both side
12	Tapping PCD		35 n/c	
13	Tapping Hole Diameter		⌀3.0 n/c. Check by ⌀3.0" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raoi 25/8/23

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	4.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth		9 n/c		5 n/c					
4	Inspection Done Before Hardening By (Name)				Raoi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		25	8	23					

Inspected By (Sign) & Date

Raoi 25/8/23

Reviewed by (Engineer-CNC)

Manager-QA