



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.		9756	50/55
2	Machined By		V.T.L n/c Shop	Drg No. L.S.D. 855
3	Pallet Die No.		10493 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SS70	
5	Out Side Diameter	Drg. No.	629.8 n/c Ⓣ Step OD = 612 n/c	Step length = 2mm
6	Inside Diameter	Drg. No.	Ⓣ 520.12 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c / 13x8x3 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 = 12 Both Side
12	Tapping PCD		565 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 17/6/23

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							Row = 25
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		13 n/c		5 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				17	6	23		

Inspected By (Sign) & Date

Ravi 17/6/23

Reviewed by (Engineer-CNC)

Manager-QA