



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10948	410/40
2	Machined By		V.T.L. n/c Shop	Digital I.C.C. 15062
3	Pallet Die No.		10680 (410) n/c	Rev 200
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500mm Step OD: 498.83	Tap size 12"
6	Inside Diameter	Dr. No.	490.12mm	Step length: 13"
7	Width of Pellet Die	Dr. No.	158mm	
8	Grooves as per Drawing	Dr. No.	12x8x3mm 10x8x3mm	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	[Tapping No of holes = 8 Bottom Side]
12	Tapping PCD		450mm	
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: 19.8mm Tapping Depth: 17.2mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/9/23

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								Ravi 9/9/23
2	External Relief Dia	4.3mm	Outside (2-2)		Inner					
3	External Relief Depth		4mm		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date		9	9	23					

Inspected By (Sign) & Date

Ravi 9/9/23

Reviewed by (Engineer-CNC)

Manager-QA