



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.			
2	Machined By		10191	33/40
3	Pallet Die No.		V.T.L. N/C Shop	Dy No. 1-20, 15-62
4	Die Category	Drg. No.	9774 (3.5) N/C	Rev 02
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500.2 N/C Step OD, Tapper, 12° Step length	13
7	Width of Pellet Die	Drg. No.	420.12 N/C	
8	Grooves as per Drawing	Drg. No.	158 N/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 N/C / 12x8x3 N/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes, 8 Both Side
12	Tapping PCD		454 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, 18.5 N/C Tapping Depth, 16.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 4/9/23

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								
2	External Relief Dia	3.8 N/C	Outside (2-2)		Inner					
3	External Relief Depth		10 N/C		7 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			4	9	23				

Inspected By (Sign) & Date Ravi 4/9/23

Reviewed by (Engineer-CNC) 4/9/23

Manager-QA