



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.		10189	49/51
2	Machined By		V.T.L. n/c Shop	Drg No. 1.3.0. 537
3	Pallet Die No.		10772 (3.5) n/c	Row 2 OK
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	732 n/c Step OD = 743 n/c	Side length = 27.5
6	Inside Diameter	Drg. No.	630.12 n/c	Tabber = 4
7	Width of Pellet Die	Drg. No.	255 n/c	Under cut = 5.5 n/c
8	Grooves as per Drawing	Drg. No.	22 x 8 x 7 n/c / 22 x 8 x 7 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		685 n/c	
13	Tapping Hole Diameter		M22 - Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 28.5 n/c Tapping Depth = 28.7	
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								Row: 38
2	External Relief Dia	4.0 n/c	4.0 n/c	All Lines						
3	External Relief Depth			3 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)
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Manager-QA