



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.		10493 ✓	32/40/50
2	Machined By		V.T.L. n/c Shop	Drg No. I.S.D = 859
3	Pallet Die No.		10839 (4.0) ✓	Rev = 09
4	Die Category	Drg. No.	Ext outside	
5	Out Side Diameter	Drg. No.	620 H4 ✓	① Tappet = 12"
6	Inside Diameter	Drg. No.	520.12 H4 ✓	Step length = 18 H4
7	Width of Pellet Die	Drg. No.	222 H4 ✓	Under cot = 1.5 H4
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 ✓	
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	Tapping PCD		565 H4 ✓	
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 H4 ✓	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/10/23

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Ravi = 31
2	External Relief Dia	4.3 H4 / 4.8 H4	4.3 H4 All Lines	4.8 H4 All Lines				
3	External Relief Depth		18 H4	10 H4				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		11	10	23			

Inspected By (Sign) & Date

Ravi 11/10/23

Reviewed by (Engineer-CNC)

Manager-QA