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.		10423	39/40/50
2	Machined By		V.T.L. M/c Shop	Drg No. 1.S.D.259
3	Pallet Die No.		10840 (4.0) HY	Rev. 02
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 HY Step OD = 623 HY	Step length = 18 HY
6	Inside Diameter	Drg. No.	5 20.12 HY	Tapper = 12°
7	Width of Pellet Die	Drg. No.	22 HY	Undercut = 1.5 HY
8	Grooves as per Drawing	Drg. No.	13×8×5 HY / 13×8×5 HY	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 HY	
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 HY	Tapping Depth = 18
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	

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

1	Counter Sinking Depth & Finish	ok						Row = 31
2	External Relief Dia	4.3HH / 4.8HY	4.3HH	All Lines	4.8HY	All Lines		
3	External Relief Depth		18 HY			10 HY		
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					

Satya 11/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner