



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.		10457	35/40
2	Machined By		V. T. L. n/c Shop	Drg No. L&C/15-02
3	Pallet Die No.		10709 (3.5) n/c	Rev. 02
4	Die Category	Drg. No.	Seator	
5	Out Side Diameter	Drg. No.	500 n/c / Step 002 498.88 Tappers 12"	
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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 8 Bottom 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 19.8 n/c	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/10/23

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							Ravi 23
2	External Relief Dia	4.0 n/c	Outside 2.25		Inner				
3	External Relief Depth		9 n/c		5 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark For race
6	Material Sent For Hardening On Date		23	10	23				

Inspected By (Sign) & Date

Ravi 23/10/23

Reviewed by (Engineer-CNC)
23/10/23

Manager-QA