



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.		10450/	33/40
2	Machined By		V.T.L. H/c Shop	Drg No. L.E.C. 5062
3	Pallet Die No.		10701 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Step 00: 498.88	Tappers 12"
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	1248x3 H/c / 1248x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H/c	Tapping Depth 17.3
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 24
2	External Relief Dia	3.5 H/c	outside (2-2)		Inner					
3	External Relief Depth		13 H/c		7 H/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		23	10	23					

Inspected By (Sign) & Date

Ravi 23/10/23

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

Manager-QA