



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.		10494	36/50
2	Machined By		N.T.L. N/C Shop	Drg No. L.S.O. 670
3	Pallet Die No.		9613 (3.0) H4	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H4	
6	Inside Diameter	Drg. No.	Step OD: 803 H4	Tapper 2 10°
7	Width of Pellet Die	Drg. No.	660.12 H4 / Bore 659.6	Step length 30 H4
8	Grooves as per Drawing	Drg. No.	290 H4	Under cut 21.5 H4
9	Fitting Sizes on CNC Plate	Drg. No.	27x8x7.5 H4 / 27x8x7.5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of holes 12 Both side
13	Tapping Hole Diameter		724 H4	
14	Tapping On Second Side	Half pitch of 1st side	M22 = Check by M22 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 29.8 H4	Tapping Depth: 27.8
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 27/10/23

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							
2	External Relief Dia	3.3 H4	Outside (3-3)		Inner				Rev 2.00
3	External Relief Depth		20 H4		14 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		27	30	23				

Inspected By (Sign) & Date

Ravi 27/10/23

Reviewed by (Engineer-CNC)

Manager-QA