



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.		10554	35/45
2	Machined By		V.T.L N/C Shop	Drg no. 18.02-912
3	Pallet Die No.		10993 (3.0) N/C	Rev 200
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	510 N/C Step OD = 499 N/C	Tappers = 12"
6	Inside Diameter	Drg. No.	420.12 N/C	step length = 17 N/C
7	Width of Pellet Die	Drg. No.	186 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	Tapping no of holes 8 Both side
12	Tapping PCD		454 N/C	
13	Tapping Hole Diameter		ø3/4" = Check by ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19.8 N/C	Tapping Depth = 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/10/23

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							Rev 31
2	External Relief Dia	3.5 N/C	Outside (3/3)	Inner					
3	External Relief Depth		16 N/C	10 N/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		28	10	23				

Inspected By (Sign) & Date

Ravi 28/10/23