



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.		9815	34/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1.2.2.998
3	Pallet Die No.		10019 (2.8) H/c	Rev: 00
4	Die Category	Drg. No.	2x2x2 side	
5	Out Side Diameter	Drg. No.	62.0 H/c	Step 00 = Tapper = 12° Step length = 18
6	Inside Diameter	Drg. No.	52.12 H/c	
7	Width of Pellet Die	Drg. No.	22.2 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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 = 12 Both Side]
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 28/6/23

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: 40
2	External Relief Dia	3.1 H/c	outside (3-3)		Inner			
3	External Relief Depth		22 H/c		16 H/c			
4	Inspection Done Before Hardening By (Name)							Rao
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		28	6	23			

Inspected By (Sign) & Date

Rao: 28/6/23

Reviewed by (Engineer-CNC)

Manager-QA