



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.		10394 ✓	27/50/65
2	Machined By		V.T.L. n/c Shop	Drg No. 150.698
3	Pallet Die No.		11005 (3.8) H-H	Rev 200 ✓
4	Die Category	Drg. No.	Jumbo ✓	
5	Out Side Diameter	Drg. No.	830 H-H, Step OD, 823 H-H	Tappers ✓
6	Inside Diameter	Drg. No.	700.12 H-H	Step length 33 H-H
7	Width of Pellet Die	Drg. No.	324 H-H	
8	Grooves as per Drawing	Drg. No.	30x8x8.5 H-H / 30x8x8.4 H-H	
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 = 12 Both Side
12	Tapping PCD		760 H-H ✓	
13	Tapping Hole Diameter		M22 - Check by M22 B-1 ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 36.5 H-H	Tapping Depth = 34.4 H-H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/23

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Rev. 46
2	External Relief Dia	4.3 H-H / 4.8 H-H	4.3 H-H All Lines	4.8 H-H All Lines				
3	External Relief Depth		38 H-H	15 H-H				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		1	11	23			

Inspected By (Sign) & Date

Ravi 11/1/23

Reviewed by (Engineer-CNC)

Manager-QA