



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.		10479	44/48
2	Machined By		V.T.L. H/c Shop	Dy. No. L.S.No. 518
3	Pallet Die No.		10785 (2.0) H/c	Rev 2.00
4	Die Category	Drg. No.	7820	
5	Out Side Diameter	Drg. No.	726 H/c Step OD = 743 H/c	Tapped 10°
6	Inside Diameter	Drg. No.	630.12 H/c	Step length 23 H/c
7	Width of Pellet Die	Drg. No.	290 H/c	Under cut = 8.75
8	Grooves as per Drawing	Drg. No.	1548 x 5 H/c / 1548 x 5 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: 16 Both Side
12	Tapping PCD		385 H/c	
13	Tapping Hole Diameter		M20 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			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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Rev = 52
2	External Relief Dia	3.5 H/c	Outside (3-3)	Inner
3	External Relief Depth		11 H/c	4 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For more	
6	Material Sent For Hardening On Date		11	23
Inspected By (Sign) & Date			Ravi 11/1/23	

Reviewed by (Engineer-CNC)

Manager-QA