



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.		10614	40/50
2	Machined By		V.T.L. n/c Shop	Drg No. 18.0.405
3	Pallet Die No.		11246 (3.5) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Step OD = 499 n/c	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 12 n/c
7	Width of Pellet Die	Drg. No.	158 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 Shop	Tapping No. of holes = 8
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0.034" = Check by 0.034" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.6 n/c Tapping Depth = 16.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/11/23

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	4.0 n/c	outside (2-2)		inner				
3	External Relief Depth	/	17 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Purvace
6	Material Sent For Hardening On Date			1	11	23			

Inspected By (Sign) & Date

Ravi 11/11/23

Reviewed by (Engineer-CNC)

Manager-QA