



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.		10497	40/55
2	Machined By		V.T.L. H/c Shop	Drg No = 1.20.14924
3	Pallet Die No.		11022 (8.0) H/c	Reo 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630 H/c Step OD x 612 H/c	Step length = 19.5
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/c / 13 x 8 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 = 12 Bolt Side
12	Tapping PCD		565 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 = 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 30/10/23

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							Reo = 18
2	External Relief Dia	8.5 H/c	outside (2.3-3)		Inner				
3	External Relief Depth		23 H/c		15 H/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		20	10	23				

Inspected By (Sign) & Date Ravi 30/10/23

Reviewed by (Engineer-CNC) Saha 30/10/23

Manager-QA