



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.		10304	40/40
2	Machined By		V.T.L. N/C Shop	Dy. No. Task 13310
3	Pallet Die No.		11198 (4.0) H4	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H4, Step OD = 395 H4	Step length = 14.5
6	Inside Diameter	Drg. No.	32.012 H4	
7	Width of Pellet Die	Drg. No.	142 H4	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H4 15.5 x 7 x 2 H4	
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 Both Side
12	Tapping PCD		355 H4	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H4	Tapping Depth = 18.8 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/11/23

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							Ravi 16
2	External Relief Dia	U.5 H4	outside (2-2)		Inner				
3	External Relief Depth		4 H4		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date								4 11 23

Inspected By (Sign) & Date

Ravi 4/11/23

Reviewed by (Engineer-CNC)

Manager-QA