



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.		9787	36/55
2	Machined By		V. T. L. H/c Shop	Drg No. I.S.O. 347
3	Pallet Die No.		9407 (G.O) H/V	Rev: 00
4	Die Category	Drg. No.	Ext outside.	
5	Out Side Diameter	Drg. No.	630 H/V, Step 00 = 624.7 H/V	Tabber = 12
6	Inside Diameter	Drg. No.	520.12 H/V	Step length, 18 H/V
7	Width of Pellet Die	Drg. No.	222 H/V	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/V 13x8x5 H/V	
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 Both Side
12	Tapping PCD		505 H/V	
13	Tapping Hole Diameter		M20 Chack by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 20.4 H/V	Tapping Depth, 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 30/6/23	
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	6.5 H/V	Outside (3-3)	Inner
3	External Relief Depth		25 H/V	19 H/V
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30	6 23
Inspected By (Sign) & Date			Ravi 30/6/23	

Reviewed by (Engineer-CNC)

Manager-QA