



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.		10527	45/65
2	Machined By		V.T.L. n/c Shop	Dy No. 18.02.84
3	Pallet Die No.		11007 (3.0) n/c	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 n/c, Step 002 803 n/c	Tap length 12"
6	Inside Diameter	Drg. No.	740.12 n/c	Step length 43 n/c
7	Width of Pellet Die	Drg. No.	340 n/c	
8	Grooves as per Drawing	Drg. No.	37x8x12 n/c 37x8x12.1 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: 12 Both side
12	Tapping PCD		742 n/c	
13	Tapping Hole Diameter		M16 Check by H16 B. H	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 28.4 n/c	Tapping Depth: 24 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date: Ravi 21/11/23

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								Ravi 54
2	External Relief Dia	3.5 n/c	outside (3-3)		Inner					
3	External Relief Depth		26 n/c		20 n/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			7	11	23				

Inspected By (Sign) & Date: Ravi 21/11/23

Reviewed by (Engineer-CNC): [Signature] 21/11/23

Manager-QA