



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.		10655	45/50
2	Machined By		V.T.L. n/c Shop	Dy No. L.S.O. 442
3	Pallet Die No.		11344 (8.0) n/c	Reo = ok
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c	Step 00 = 492 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Step length = 13.5
7	Width of Pellet Die	Drg. No.	159 n/c	
8	Grooves as per Drawing	Drg. No.	7x7x5 n/c 7x7x5 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 Both Side
12	Tapping PCD		455 n/c 454.9 n/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.4 n/c	Tapping Depth = 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 15/11/23

1	As per programme no.			20mm width 7mm Depth Both Side
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						Raw = 12
2	External Relief Dia	3.3 n/c	outside (2-2)	Inner				
3	External Relief Depth	/	13 n/c	5 n/c				
4	Inspection Done Before Hardening By (Name)		/	Raw				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		15	11	23			
Inspected By (Sign) & Date		Raw: 15/11/23						

Reviewed by (Engineer-CNC)

Manager-QA