



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.		9795	34/50
2	Machined By		V.T.L. n/c Shop	Dry Holes - S.D. 514
3	Pallet Die No.		9056 (2.8) n/c	Rev. 00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	620 n/c Step OD = 621.5 n/c	Tabber = 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length = 21.5
7	Width of Pellet Die	Drg. No.	186 n/c	Under cut = 20.75 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/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 n/c Tapping Depth = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/8/23

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 31
2	External Relief Dia	3.1 n/c	Outside (2-3)		Inner					
3	External Relief Depth		22 n/c		16 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		29	6	23					

Inspected By (Sign) & Date

Ravi 29/8/23

Reviewed by (Engineer-CNC)

Manager-QA