



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.		9752	
2	Machined By		V.T.L. n/c Shop	33/50
3	Pallet Die No.		10234 (3.0) n/c	Drg No. 1.80.505
4	Die Category	Drg. No.	N. Jumbo	Rev. 00
5	Out Side Diameter	Drg. No.	730 n/c	
6	Inside Diameter	Drg. No.	Step OD: 742.8 n/c	Tapper 4°
7	Width of Pellet Die	Drg. No.	830.12 n/c	Step length: 27.5
8	Grooves as per Drawing	Drg. No.	854.9 n/c	Undercut: 6.4 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	82.8 x 6.9 n/c 82.8 x 7 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		685 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M22 Check by M22 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth: 28.4 n/c	Tapping Depth: 28.7
17	Visual Inspection Before Gun Drilling		Yes OK	
Inspected By (Sign) & Date			Ravi 29/6/23	
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		2.5 n/c	Row = 42
3	External Relief Depth		Outside (3-3) 23 n/c Inner 17 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 29/6/23	

Reviewed by (Engineer-CNC)

Manager-QA