



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.		10717	32/55	
2	Machined By		V.T.L.H/C Shop	Dy No. 18.0.430	
3	Pallet Die No.		11237 (5.0)H/C	Rev. No.	
4	Die Category	Drg. No.	M. Jumbo		
5	Out Side Diameter	Drg. No.	710 H/C Step OD = 692 H/C Step length 19.5		
6	Inside Diameter	Drg. No.	300.12 H/C		
7	Width of Pellet Die	Drg. No.	222 H/C		
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/C 12.5 x 8 x 7 H/C		
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 Botu Side	
12	Tapping PCD		345 H/C		
13	Tapping Hole Diameter		H20 = Check by H20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth 29.5 H/C Tapping Depth 20.9 H/C		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 20/11/23		
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		
Note : Mark the defective holes/Missed holes with the help of Permanent Marker					
1	Counter Sinking Depth & Finish	OK		Ravi 22	
2	External Relief Dia	5.8 H/C	Outside (3-3)	Innen	
3	External Relief Depth		27 H/C	23 H/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		20	11	23
Inspected By (Sign) & Date			Ravi 20/11/23		

Reviewed by (Engineer-CNC)

Manager-QA