



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.		10696	22/40
2	Machined By		V.T.C. n/c Shop	Drg. No. 1-5-D-335
3	Pallet Die No.		10717 (2.8) n/c	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5000 n/c Step OD = 491 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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		454 n/c	
13	Tapping Hole Diameter		003/4" - Check by 003/4" Bul	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth - 16.8 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

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

1	Counter Sinking Depth & Finish	OK								<i>Ravi 22</i>
2	External Relief Dia	3.3 n/c	Outside (2-2)		Inner					
3	External Relief Depth		20 n/c		18 n/c					
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>							
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>							
6	Material Sent For Hardening On Date		21	11	23					

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

Reviewed by (Engineer-CNC) *Saty 21/11/23*

Manager-QA