



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.		10738 ✓	41/55 ✓
2	Machined By		V.T. L. n/c Shop	Drg No. 680 ✓
3	Pallet Die No.		11382 (3.5) ✓	Row 2 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 ✓, Step OD 791 ✓ 790.8 ✓	Step length 27 ✓ 27.4 ✓
6	Inside Diameter	Drg. No.	660.12 ✓	
7	Width of Pellet Die	Drg. No.	324 ✓	Under cut = 10.5 ✓ 10.2 ✓
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 12 ✓ / 21.5 x 8 x 12 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping at of holes = 12 Both Side
12	Tapping PCD		725 ✓	
13	Tapping Hole Diameter		M20 Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 31.4 ✓	Tapping Depth. 29.8 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 24/11/23

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							Row = 52
2	External Relief Dia	4.0 ✓	outside (3-3)		Inner				
3	External Relief Depth		22 ✓		15 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date		24		11		25		

Inspected By (Sign) & Date Ravi 24/11/23

Reviewed by (Engineer-CNC)

Manager-QA