



Lark Engineering Co. (India)
ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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.		10759	5512
2	Machined By		V.T.L. H/c Shop	Drg No. 1.8.02.935
3	Pellet Die No.		11107 (3.5) H/c	Rev=00
4	Die category	Drg. No.	Outside	
5	Outside diameter	Drg. No.	64.0mm / Step OD = 62.5mm	Tapper 12°
6	Inside Diameter	Drg. No.	52.14mm	Step length = 2.5
7	Width Of Pellet Die	Drg. No.	22.14mm	
8	Grooves As Per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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, 12 Both Side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		M2x2 Check by M2x2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 2.3mm	Tapping Depth = 19mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/12/23	
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		Rev=35
2	External Relief Dia.	4.0mm	Outside (3-3) / Inner	
3	External Relief Depth		1.8mm / 5mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ferrare	
6	Material Sent For Hardening On Date		4/12/23	
Inspected By (Sign) & Date			Ravi 4/12/23	

[Signature]
4/12/23
Reviewed by (Engineer (CNC))

Manager-QA