



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.		9759	
2	Machined By		V.T.L. n/c Shop	36/40
3	Pallet Die No.		8763 (3.0) n/c	Dr. No. 1.50.830
4	Die Category	Drg. No.	Junior	Rev 2.01
5	Out Side Diameter	Drg. No.	385 n/c	Step length 9.5 n/c
6	Inside Diameter	Drg. No.	305.1 n/c	
7	Width of Pellet Die	Drg. No.	125 n/c	
8	Grooves as per Drawing	Drg. No.	6.5 x 6 x 4.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	6.5 x 6 x 4.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		350 n/c	Tapping No of Holes - 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	1/2" - Check by 1/2" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 15.5 n/c	Tapping Depth 13.2
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Rao: 31/7/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		ok

No - 1 Hole Coloured (A)

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

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.3 n/c	Outside (2-2)		Inner		low go
3	External Relief Depth		10 n/c		4 n/c		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date						

Inspected By (Sign) & Date

Rao: 31/7/23

Reviewed by (Engineer-CNC)

Manager-QA