



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.		10765	40/50
2	Machined By		V.T.L. N/C Shop	Drg No. (B.O. 2) No. 3
3	Pellet Die No.		11338 (B.S) H4	Row 200
4	Die category	Drg. No.	Senior	
5	Outside diameter	Drg. No.	520 H4 / Step OD: 491 H4	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width Of Pellet Die	Drg. No.	158 H4	
8	Grooves As Per Drawing	Drg. No.	12 x 8 x 3 H4 / 12 x 8 x 3 H4	
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 H4	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 19 H4	Tapping Depth: 17 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 11/12/23

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		Row 201
2	External Relief Dia.	4.3 H4	outside 2.25 / inner 1.0 H4	
3	External Relief Depth		14 H4 / 10 H4	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Portace	
6	Material Sent For Hardening On Date		11/12/23	

Inspected By (Sign) & Date Ravi 11/12/23

[Signature]
11/12/23

Reviewed by (Engineer (CNC))

Manager-QA