



Lark Engineering Co. (India)
 ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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.		10766 ✓	3640 gms
2	Machined By		V.T.L H/C Shop	Drg. No. last 2 SS10
3	Pellet Die No.		10725 (3.0) H/C	
4	Die category	Drg. No.	Senior	
5	Outside diameter	Drg. No.	499.8 H/C Step 00 =	490.8 H/C Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width Of Pellet Die	Drg. No.	158 H/C	
8	Grooves As Per Drawing	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of holes = 8 Both side
12	Tapping PCD		454 H/C / 453.9 H/C	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.8 H/C	Tapping Depth = 17 H/C
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 = 24
2	External Relief Dia.	3.3 H/C	Outside / Inner	
3	External Relief Depth		10 H/C / 4 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11/12/23	

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

Satyam
 11/12/23
 Reviewed by (Engineer (CNC))

Manager-QA