



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.		10818 ✓	
2	Machined By		N.T.C. H/C Shop	35/03/28 ✓
3	Pellet Die No.		10904 (G.O) H/C	Dy. No. 18.P. 396
4	Die category	Drg. No.	N. Jumbo	Rev. 02 ✓
5	Outside diameter	Drg. No.	636 H/C / 632 H/C / Step 002 830.5 H/C / 543 H/C	
6	Inside Diameter	Drg. No.	480.1 H/C / 489.1 H/C / 500.1 H/C	Step length 86 H/C
7	Width Of Pellet Die	Drg. No.	182 H/C	16.5 H/C
8	Grooves As Per Drawing	Drg. No.	37x12x8x9.5 H/C / 37x12x8x9.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		540 H/C	Tapping No. of Holes: 4
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1st Side One Slot	
15	Tapping Hole Depth		Drill Depth: 98.4 H/C	Tapping Depth: 86.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/2/23	
1	As per programme no.		_____	1 Slot 98.1 H/C width 17 H/C Depth
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		Rep 2 10
2	External Relief Dia.	6.5 H/C / 7.0 H/C	6.5 H/C All Cms / 7.0 H/C All Cms	
3	External Relief Depth		43 H/C / 15 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		11/2/23	
Inspected By (Sign) & Date			Ravi 11/2/23	

Reviewed by (Engineer (CNC))
[Signature]
 11/2/23

Manager-QA