



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.		10760/	40/55
2	Machined By		V.T.L. M/c Shop	Drg No. 18.0 = 557
3	Pellet Die No.		11030 (8.0) MM	Rev = 00
4	Die category	Drg. No.	SS3TD	
5	Outside diameter	Drg. No.	630 MM Step OD = 624 MM Tapper = 12	
6	Inside Diameter	Drg. No.	590.12 MM	Step length = 30 MM
7	Width Of Pellet Die	Drg. No.	189 MM	
8	Grooves As Per Drawing	Drg. No.	12x10x5 MM 12x10x5 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 11 MM Tapping Depth = 19 MM	
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.		_____	
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 = 14
2	External Relief Dia.	8.3 MM	outside (2-3)	
3	External Relief Depth		8.3 MM Inner 15 MM	
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	

Satyam
 Reviewed by (Engineer (CNC))

Manager-QA