



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. N/C Shop	Drg No. 18.0.557
3	Pellet Die No.		11031 (8.0) H/H	Rev. 00
4	Die category	Drg. No.	SS310	
5	Outside diameter	Drg. No.	630 H/H, Step OD = 624 H/H	Tappers 12
6	Inside Diameter	Drg. No.	520.12 H/H	Step length 20 H/H
7	Width Of Pellet Die	Drg. No.	182 H/H	
8	Grooves As Per Drawing	Drg. No.	12x10x5 H/H / 12x10x5 H/H	
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 = 12 Both Side
12	Tapping PCD		565 H/H	
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 = 21 H/H	Tapping Depth = 19 H/H
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 H/H	outside 23 H/H / Inner 15 H/H	
3	External Relief Depth		23 H/H / 15 H/H	
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				

Sotya
11/2/23

Reviewed by (Engineer (CNC))

Manager-QA