



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.		10768	93/50
2	Machined By		V.T.L. N/C Shop	Drg. No. (3.0) 345
3	Pellet Die No.		9971 (3.0) N/C	Rev. 01
4	Die category	Drg. No.	N. Jumbo	
5	Outside diameter	Drg. No.	700 N/C	Step OD, 693 N/C
6	Inside Diameter	Drg. No.	600.12 N/C	Tapper = 12°
7	Width Of Pellet Die	Drg. No.	222.1 N/C	Step length, 20 N/C
8	Grooves As Per Drawing	Drg. No.	14x8x7 N/C	
9	Fitting Sizes on CNC Plate	Drg. No.	14x8x7 N/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		640 N/C	Tapping No of Holes 12 Both Side
13	Tapping Hole Diameter		N202 Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 23.3 N/C	Tapping Depth 21 N/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 4/12/23	
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 = 37
2	External Relief Dia.	3.3 N/C	Outside (2.3-3) / Inner	
3	External Relief Depth		21 N/C / 18 N/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		4/12/23	
Inspected By (Sign) & Date			Ravi 4/12/23	

Satyam
4/12/23
Reviewed by (Engineer (CNC))

Manager-QA