



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.		10768	35/5
2	Machined By		V.T.L. n/c Shop	Drill No. 18.0.245
3	Pellet Die No.		9972 (4.0) n/c	Rev. 01
4	Die category	Drg. No.	M. Jumbo	
5	Outside diameter	Drg. No.	700 n/c	Step OD: 692.3 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tapper: 12 Step length: 20 n/c
7	Width Of Pellet Die	Drg. No.	222 n/c	
8	Grooves As Per Drawing	Drg. No.	14x8x7 n/c / 14x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holder: 12 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 23.3 n/c	Tapping Depth: 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 7/12/23	
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: 31
2	External Relief Dia.	4.5 n/c	Outside 23.3 / Inner	
3	External Relief Depth		19 n/c / 15 n/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		7/12/23	
Inspected By (Sign) & Date			Ravi 7/12/23	

Reviewed by (Engineer (CNC))
Satyam 7/12/23

Manager-QA