



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.		10813	33/45
2	Machined By		V. T. L. H/C Shop	Dy. No. LEC-15430
3	Pellet Die No.		11103 (3.0) H/H	Rev. No.
4	Die category	Dr. No.	Outside	
5	Outside diameter	Dr. No.	610 H/H Step OD = 812 H/H	Step length 20 H/H
6	Inside Diameter	Dr. No.	520.12 H/H	Under cot + 1 H/H
7	Width Of Pellet Die	Dr. No.	222 H/H	
8	Grooves As Per Drawing	Dr. No.	13x8x5 H/H / 13x3x5 H/H	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		56.5 H/H	
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 = 21.3 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 31/7/23*

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 = 38
2	External Relief Dia.	3.5 H/H	Outside (3.3)	Inner
3	External Relief Depth		18 H/H	12 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		31/7/23	

Inspected By (Sign) & Date *Ravi 31/7/23*

Ravi
31/7/23
Reviewed by (Engineer (CNC))

Manager-QA