



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.		10820	30/48
2	Machined By		V.T.G. H/C Shop	Dy. No. 18.0. 757
3	Pellet Die No.		8882 (3.0)	Reas. co
4	Die category	Drg. No.	MJED	
5	Outside diameter	Drg. No.	696 H/H Step OD > 700.8 H/H Tapper 12°	
6	Inside Diameter	Drg. No.	600.12 H/H	Step length the 24 H/H
7	Width Of Pellet Die	Drg. No.	265 H/H	Under cut 2 3.4 H/H
8	Grooves As Per Drawing	Drg. No.	15x8x7 H/H / 15x8x7 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 16 Both Side
12	Tapping PCD		340 H/H	
13	Tapping Hole Diameter		M2 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21.4 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 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		Low = 46
2	External Relief Dia.	3.5 H/H	Outside 9.3-3.9	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		7/12/23	
Inspected By (Sign) & Date		Ravi 7/12/23		

Satyam
7/12/23

Reviewed by (Engineer (CNC))

Manager-QA