Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10474	28/45
2	Machined By		V.T.L M/c Shop	Drg No: I.S.D. 519
3	Pallet Die No.		9829 (2.8) MM	Rev: 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 MM, Step OD: 692 MM	Step length: 20MM
6	Inside Diameter	Drg. No.	600.12 MM	Udercut: 1MM
7	Width of Pellet Die	Drg. No.	222 MM	
8	Grooves as per Drawing	Drg. No.	15x8x7 MM / 15x8x7 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes: 12 Both Side
12	Tapping PCD		640 MM	
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: 20.4 MM	Tapping Depth: 18.8 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 15/12/23	
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						Rev: 39
2	External Relief Dia	3.1 MM	Outside (3-3)		Inner			
3	External Relief Depth		20 MM		17 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		15	12	23			
	Inspected By (Sign) & Date		Ravi 15/12/23					

Satya 15/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner