



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (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.			
2	Machined By		9854	50/60
3	Pallet Die No.		V.T. Lile Shop	Drg No. L.S.O. 409
4	Die Category	Drg. No.	8724 (4.0) 44	Rev 200
5	Out Side Diameter	Drg. No.	58870	
6	Inside Diameter	Drg. No.	639.9 44 / Step OD = 611.9 44	Step length 19.4
7	Width of Pellet Die	Drg. No.	520.12 44	
8	Grooves as per Drawing	Drg. No.	188 44	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 44 / 13x8x3 44	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	Tapping No of Holes = 12 Both Side
13	Tapping Hole Diameter		565 44	
14	Tapping On Second Side	Half pitch of 1st side	H20 Check by H20 Belt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth. 20.4 44	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Rao: 5/7/23

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

Pellet After Rev-00 of 10/08/13 as Rev-01 was shown late

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 44	outside (3-3)		Inner			Rao: 25
3	External Relief Depth		18 44		10 44			
4	Inspection Done Before Hardening By (Name)							Rao:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			5	7	23		

Inspected By (Sign) & Date

Rao: 5/7/23

Tourist 5/7/23

Reviewed by (Engineer-CNC)

Manager-QA