



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		9845	40/50
3	Pallet Die No.		V.T.C. H/c Shop	Drg No. 10620
4	Die Category	Drg. No.	10620 (4.0) H/c	
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	620 H/c Step OD = 612 H/c	Step length 19.4
7	Width of Pellet Die	Drg. No.	520.12 H/c	
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c 13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4 H/c	Tapping Depth = 18.8
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Raoi 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 - 1 Hole Closed

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 H/c	Outside (3-3)					Raoi 31
3	External Relief Depth		14 H/c		Inner	10 H/c		
4	Inspection Done Before Hardening By (Name)							Raoi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			5	7	23		

Inspected By (Sign) & Date

Raoi 5/7/23

Tanwar 5/7/23