



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.		10978	35/50
2	Machined By		V.T.L n/c Shop	Dry Hole S.O. 947
3	Pallet Die No.		11059 (3.5) n/c	Rev. 00
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	52.0 n/c Step 02: 499 n/c	Tappers 12" ②
6	Inside Diameter	Drg. No.	42.0 12 n/c	Step length th = 16.7
7	Width of Pellet Die	Drg. No.	185.3 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 2 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0.314" = Check by 0.316" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 n/c	Tapping Depth = 17.4 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/1/24	
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	Counter: 60°	
2	External Relief Dia	4.0 n/c	outside (2-2)	Inner
3	External Relief Depth		17 n/c	15 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4	1
Inspected By (Sign) & Date			Ravi 4/1/24	

Reviewed by (Engineer-CNC) *Sakshi 4/1/24*

Manager-QA