



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		11036	22/40
3	Pallet Die No.		V.T.L. H/C Shop	Dr. H. L.B.D. 21
4	Die Category	Drg. No.	10943 (2.8) H/C	Rev 201
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/C, Step 002, 499 H/C	Taper 12°
7	Width of Pellet Die	Drg. No.	42.12 H/C	Step length 12 H/C
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	Tapping Holes, Both Side
13	Tapping Hole Diameter		0.314" Check by 0.314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.2 H/C	Tapping Depth 17.2 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/1/24

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	3.3 H/C	Outside (2-2)	Inner			Rev 201
3	External Relief Depth		20 H/C	18 H/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		5	1	24		

Inspected By (Sign) & Date

Ravi 5/1/24

Reviewed by (Engineer-CNC)

Manager-QA