



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.		10983	46/50
2	Machined By		V.T.L. H/C Shop	Drg No. 1-3-9-742
3	Pallet Die No.		11331 (8.0) H/C	Rec. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C, Step OD, 492 H/C	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	Tapping no. of holes = 8 Both Side
13	Tapping Hole Diameter		M202 Chack by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.2 H/C	Tapping Depth = 17.1 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. Ge
2	External Relief Dia	8.5 H/C	Outside (2-2)		Inner			Rec 12
3	External Relief Depth		12 H/C		4 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)
5/01/24

Manager-QA