



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.		10998	43/45
2	Machined By		N.T.L. H/c Shop	Drg No. L.S.D. 904
3	Pallet Die No.		11144 (3.0) H/H	Rev. 00
4	Die Category	Drg. No.	3220	
5	Out Side Diameter	Drg. No.	510 H/H, Step 00 = 498.88 H/H	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 H/H	Step length 17.8 H/H
7	Width of Pellet Die	Drg. No.	182 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of holes = 8 Back Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		M20, Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 H/H	Tapping Depth = 17.2 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/11/24

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							Counters = 60° Rov = 30
2	External Relief Dia	3.5 H/H	outside (2-2)		Inner				
3	External Relief Depth		9 H/H		3 H/H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		20	1	24				

Inspected By (Sign) & Date

Ravi 20/11/24

Satyam
20/11/24

Reviewed by (Engineer-CNC)

Manager-QA