



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.		11156	40/50
2	Machined By		N.T.C H/C Shop	Dy No. 1-86 998
3	Pallet Die No.		11593(4.0) H/C	Rev 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/C Step 00: Taper 12°	
6	Inside Diameter	Drg. No.	520.12 H/C	Step length = 18.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 13x8x5 H/C	
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 = 2 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M2 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 H/C Tapping Depth = 19 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 23/1/24

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								Coord. = 60° Page 31
2	External Relief Dia	4.5 H/C	Outside (B-3)		Inner					
3	External Relief Depth		14 H/C		10 H/C					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Roxace
6	Material Sent For Hardening On Date		23	1	24					

Inspected By (Sign) & Date Ravi 23/1/24

Reviewed by (Engineer-CNC) [Signature] 23/1/24

Manager-QA