



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.		11129	50/60
2	Machined By		V.T.L n/c Shop	Drig No. 1302409
3	Pallet Die No.		10201 (4.0) H4	Rev. 00
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	640 H4, Step OD = 612 H4	Step length 7.4
6	Inside Diameter	Drg. No.	520.12 H4	
7	Width of Pellet Die	Drg. No.	186.1 H4	
8	Grooves as per Drawing	Drg. No.	13x8 = 3 H4 / 13x8 = 3 H4	
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 = 12 Both Side
12	Tapping PCD		565 H4	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 H4 Tapping Depth = 18.8 H4	
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						Counter 60° Rev. 25
2	External Relief Dia	11.5 H4	outside (3-3)		Inner			
3	External Relief Depth		18 H4		10 H4			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Romare
6	Material Sent For Hardening On Date		23	1	24			

Inspected By (Sign) & Date

Ravi 23/1/24

[Signature]
23/1/24

Reviewed by (Engineer-CNC)

Manager-QA