



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.		11094	100/100
2	Machined By		V.T.L. H/C Shop	Drg No. 1.80.17010
3	Pallet Die No.		11033 (2.5) H/C	Rev 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 H/C	Step OD = 743.4 H/C
6	Inside Diameter	Drg. No.	630.12 H/C	Step length = 103
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C / 15x8x5 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 = 16 Bore Side
12	Tapping PCD		685 H/C	
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 = 21.4 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 25/1/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/ Missed holes with the help of Permanent Marker Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	_____							
3	External Relief Depth	_____							
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Bhat Patel
6	Material Sent For Hardening On Date		25	1	24				

Inspected By (Sign) & Date Ravi 25/1/24

Reviewed by (Engineer-CNC) Saty 25/1/24

Manager-QA