



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5607

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.			
2	Machined By		9675	40/50
3	Pallet Die No.		V.T.L n/c Shop	Dr H ₂ L.S.O 2150
4	Die Category	Drg. No.	9839(4.0) n/c	Rev 00
5	Out Side Diameter	Drg. No.	M. Jumbo	✓
6	Inside Diameter	Drg. No.	700 n/c Step 002 693 n/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	600.12 n/c	Step length 19.8 n/c
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	10710x5 n/c / 10710x5 n/c	
10	Drilling Area Surface Smoothness		ok ✓	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		640 n/c	Tapping No of holes = 12 Both side
14	Tapping On Second Side	Half pitch of 1st side	H ₂ Check by H ₂ Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Tap 20.4 n/c	Tapping Depth 18.8 n/c
17	Visual Inspection Before Gun Drilling		yes ok	
Inspected By (Sign) & Date				
1	As per programme no.			Ravi 6/6/23
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok No	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		ok	
2	External Relief Dia		4.5 n/c	
3	External Relief Depth		00Side (3-3) 14 n/c	Inner 10 n/c
4	Inspection Done Before Hardening By (Name)			
5	Material Sent For Hardening By (Name)			Ravi
6	Material Sent For Hardening On Date			Lark Purchase
Inspected By (Sign) & Date				
				Ravi 6/6/23

Reviewed by (Engineer-CNC)

Manager-QA