



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.		9812	
2	Machined By		V.T.L n/c Shop	40/55
3	Pallet Die No.		10497 (6.0) n/c	Drg No. 1.8.9.557
4	Die Category	Drg. No.	SSSTO	Rev 2.00
5	Out Side Diameter	Drg. No.	630 n/c	
6	Inside Diameter	Drg. No.	Step 002 624 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	520.12 n/c	
8	Grooves as per Drawing	Drg. No.	181.8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 5 n/c 11.7 x 8 x 5 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	[Tapping No of holes = 12 Both Side]
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	MIG - Check by MIG Bolt OK	
15	Tapping Hole Depth		Drill Depth: 20.4 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pass: 10/7/23

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								Pass-18
2	External Relief Dia	6.3 n/c	Outside (23-3)		Inner					
3	External Relief Depth		21 n/c		15 n/c					
4	Inspection Done Before Hardening By (Name)									Pass
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		10	7	23					

Inspected By (Sign) & Date

Pass: 10/7/23

Reviewed by (Engineer-CNC)

Manager-QA