



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	40/55
2	Machined By		V.T.L. n/a Shop	Drg No. 1.3.02 557
3	Pallet Die No.		10496 (8.0) n/a	Rev 2.00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	630 n/a Step OD = 624 n/a	Tabbers 12
6	Inside Diameter	Drg. No.	520.14 n/a	Step length. 20 n/a
7	Width of Pellet Die	Drg. No.	18.8 n/a	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 5 n/a 12 x 10 x 5 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	Tapping No of Holes: 12 Both Side
12	Tapping PCD		565 n/a	
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 n/a	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/7/23

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							Rev: 14
2	External Relief Dia	8.3 n/a	outside (3-3)		Inner				
3	External Relief Depth		23 n/a		15 n/a				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		11	7	23				

Inspected By (Sign) & Date

Ravi 11/7/23

Reviewed by (Engineer-CNC)

Manager-QA