



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.		9857	36/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.O. 9980
3	Pallet Die No.		10635(3.0) n/c	Rev. 00
4	Die Category	Drg. No.	(A) Extrawide	
5	Out Side Diameter	Drg. No.	619.5 n/c	Step OD, Tapper = 12 Step length = 12
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
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 n/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 = 20.4 n/c	Tapping Depth = 12.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/7/23

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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							Ravi 28
2	External Relief Dia	3.5 n/c	outside (3-3)	inner					
3	External Relief Depth		20 n/c	14 n/c					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	7	23				

Inspected By (Sign) & Date

Ravi 13/7/23

[Signature]
13/7/23

Reviewed by (Engineer-CNC)

Manager-QA