



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.		9880	45/50
2	Machined By		N.T.G. n/c Shop	Drg. no. 1.8.0.405
3	Pallet Die No.		10301 (6.0) n/c	Reo: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Step OD, 499 n/c	Step length, 17 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Tabber 2-12°
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 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, 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0314" Check by 0314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 18.4 n/c	Tapping Depth, 168
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/7/23

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							Reo: 15
2	External Relief Dia	6.5 n/c	outside (2-2)		Inner				
3	External Relief Depth		11 n/c		5 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			15	7	23			

Inspected By (Sign) & Date

Ravi 15/7/23

Tarun 15/7/23

Reviewed by (Engineer-CNC)

Manager-QA