



Lark Engineering Company (India) Pvt. Ltd.

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

7031 Hold
 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.		11429	33/40
2	Machined By		V.T.L. H/C Shop	Drg No. 1.2.02495
3	Pallet Die No.		10994 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	2910	
5	Out Side Diameter	Drg. No.	500 H/C, Step 02 = 491 H/C	Step length 16.4
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	173 H/C	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/C / 10x8.5x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		455 H/C	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21 H/C Tapping Depth 19 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 28/7/24

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 - 1 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter = 60°

1	Counter Sinking Depth & Finish	OK								Ravi 28
2	External Relief Dia	3.5 H/C	Outside (2-2)		Inner					
3	External Relief Depth		13 H/C		7 H/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		28	2	24					

Inspected By (Sign) & Date Ravi 28/7/24

Satyam
 28/7/24
 Reviewed by (Engineer-CNC)

Manager-QA