



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.		11491	32/39
2	Machined By		V.T.L n/c Shop	Drg No. L.S.O. 1001
3	Pallet Die No.		18080 (3.0) H4	Row = 00
4	Die Category	Drg. No.	Ext. inside	
5	Out Side Diameter	Drg. No.	598 H4 / Step OD = 612 H4	Step length = 2 H4
6	Inside Diameter	Drg. No.	520.12 H4	Under cut = 7 H4
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
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 H4	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.8 H4	Tapping Depth = 18.8 H4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/3/24

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 Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters = 60

1	Counter Sinking Depth & Finish	OK							Row = 38
2	External Relief Dia	2.3 H4	OK	All Rows					
3	External Relief Depth			7 H4					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date			14	3	24			

Inspected By (Sign) & Date

Ravi 14/3/24

14/3/24

Reviewed by (Engineer-CNC)

Manager-QA