



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.		9908	36/45
2	Machined By		V.T.L. n/c Shop	Drilling No. I.S.O. 300
3	Pallet Die No.		10286 (G.O) ✓	Rev. 00
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	509.8 mm (D) Step 00, 499.8 mm Step length 16.5	(A)
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 mm 10x8.5x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. 7 of Holes: 8 Both Side
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		031/12 Check by 031/12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 mm Tapping Depth: 18.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/23

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								Ravi 17
2	External Relief Dia	6.5 mm	outside (2-2)		Inner					
3	External Relief Depth	✓	15 mm		9 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark For race
6	Material Sent For Hardening On Date		17	7	23					

Inspected By (Sign) & Date

Ravi 17/7/23

Reviewed by (Engineer-CNC)

Manager-QA