



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.		11482	20/80
2	Machined By		V.T.L. H/C Shop	Drg No. 1.8.02 998
3	Pallet Die No.		12133(3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 H/C Step OD 743.4 H/C	Tapper 10°
6	Inside Diameter	Drg. No.	630.12 H/C	Step length 28 H/C
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C 15x8x5 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 = 10 Both Side
12	Tapping PCD		685 H/C	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 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 21/3/24

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 - 3 Hole Closed

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

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	—	—	no	—	Relief	—			
3	External Relief Depth									
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date Ravi 21/3/24

Reviewed by (Engineer-CNC)

Manager-QA