



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.		11016	60/65
2	Machined By		V. T. L n/c Shop	Drg. No. 18.0 951
3	Pallet Die No.		12033 (4.5) n/c	Rev. 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	549.9 n/c Step OD: 491 n/c, step length 17.4	
6	Inside Diameter	Drg. No.	420.12 n/c / 420.14 n/c (D)	
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 of Holes, 8 Both Sides
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20. Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth same as Tapping Depth. 17.6 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/3/24

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

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

Count = 60
Rev. 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0 n/c	Outside (2-25)	Inner			
3	External Relief Depth		14 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		19	3	24		

Inspected By (Sign) & Date

Ravi 19/3/24

Satya 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA