



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.		11551/	28/50
2	Machined By		V.T.L. H/C Shop	Dy. No. 1.3.02.709
3	Pallet Die No.		11967 (3.2) H/C	Rev. 1.00
4	Die Category	Drg. No.	Part 2 side	(A) to LSD-199
5	Out Side Diameter	Drg. No.	620.2 H/C / Sdcp 002 G22.5 H/C	Tabbs 10° Rev-00
6	Inside Diameter	Drg. No.	520.14 H/C (A)	Sdcp length 19.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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: 2 12 Back Side
12	Tapping PCD		565 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 20.8 H/C	Tapping Depth: 8.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 1/4/24

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

1	Counter Sinking Depth & Finish	OK							Counter 260 Rev 2 B3
2	External Relief Dia	3.5 H/C	Outside (3.3)		Inner				
3	External Relief Depth		18 H/C		12 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porroce
6	Material Sent For Hardening On Date			1	4	24			

Inspected By (Sign) & Date Ravi 1/4/24

Satya
1/4/24
Reviewed by (Engineer-CNC)

Manager-QA