



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.		11620	30/10
2	Machined By		V.T.G. H/c Shop	Drg No. 18.02.79
3	Pallet Die No.		11309 H/c	Rev 2.00
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500 H/c, Step OD = 491 H/c	Step length 154
6	Inside Diameter	Dr. No.	420.12 H/c	
7	Width of Pellet Die	Dr. No.	158 H/c	
8	Grooves as per Drawing	Dr. No.	10x8x4 H/c 10x8x4 H/c	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of holes = 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		0.314" 2 Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18 H/c Tapping Depth = 15.8 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ravi 31/7/24*

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 Sink
2	External Relief Dia	0.3 H/c	Outside (2-2)		Inner		
3	External Relief Depth		13 H/c		10 H/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		3	4	24		
Inspected By (Sign) & Date		<i>Ravi 31/7/24</i>					

Reviewed by (Engineer-CNC) *31/7/24*

Manager-QA