



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.		11590	98/40
2	Machined By		V.T.L. H/C Shop	Dr. No. 18.9 = 91
3	Pallet Die No.		11999 (2-5) H/C	Rev 201
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD = 499 H/C	Tapper 12°
6	Inside Diameter	Drg. No.	490.14 H/C	Step length 7 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	[Tapping H/C of holes = 8]
12	Tapping PCD		454 H/C	[Both side]
13	Tapping Hole Diameter		454 03/4" = Check by crane Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/C	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Rawi 5/4/24

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	2.8 H/C	Outside (2.2)		Inner				
3	External Relief Depth		18 H/C		12 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date								5 4 24

Inspected By (Sign) & Date Rawi 5/4/24

Reviewed by (Engineer-CNC)

Manager-QA