



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11632	30/40
2	Machined By		V.T.C. H/C Shop	Drg. No. 18.22863
3	Pallet Die No.		11757 (5-0) H/H	Rev. 2.0
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 H/H ~ Step 00 = 383 H/H	Step length 9.5
6	Inside Diameter	Drg. No.	315.12 H/H	
7	Width of Pellet Die	Drg. No.	108 H/H	
8	Grooves as per Drawing	Drg. No.	9.5 x 8 x 5 H/H / 9.5 x 8 x 5 H/H	
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 - 8 Both Side
12	Tapping PCD		350 H/H	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter 6

1	Counter Girking Depth & Finish	OK								Low 10
2	External Relief Dia	5.3 H/H	Outside (2-2)		Inner					
3	External Relief Depth		15 H/H		10 H/H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			5	4	24				

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

Reviewed by (Engineer-CNC) Sats 5/4/24

Manager-QA