



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.			27/55
2	Machined By		11339	Dy No. L.S.D=594
3	Pallet Die No.		N.T.L. H/c Shop	Revised
4	Die Category	Drg. No.	12289 (4.5) H/H	
5	Out Side Diameter	Drg. No.	530 H/H	Step length 7.4
6	Inside Diameter	Drg. No.	420.12 H/H [Bar = 419.8 H/H]	
7	Width of Pellet Die	Drg. No.	182 H/H	
8	Grooves as per Drawing	Drg. No.	10x8x3 H/H 10x8x3 H/H	
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. 2 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		Ø316" - Check by Ø316" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 19 H/H Tapping Depth. 17 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 6/4/24

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 23

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	5.5 H/H	Outside (2-2)		Inner			
3	External Relief Depth		32 H/H		28 H/H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Rumace
6	Material Sent For Hardening On Date			6	4	24		

Inspected By (Sign) & Date Ravi 6/4/24

Satyam
6/4/24
Reviewed by (Engineer-CNC)

Manager-QA