



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.		11664/	35/40/5.95	
2	Machined By		N.T.L. H/c Shop	Drg No. (2010)	
3	Pallet Die No.		11313(3.5) H/c		
4	Die Category	Drg. No.	Senior		
5	Out Side Diameter	Drg. No.	500 H/c, Step 00, 491 H/c	Step length 7.4	
6	Inside Diameter	Drg. No.	420.12 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		N/C Shop	[Tapping H/c of H/c = 8 Both Side]	
12	Tapping PCD		454 H/c		
13	Tapping Hole Diameter		M20 - Check by M20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 19 H/c	Tapping Depth 12 H/c	
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					
1	Counter Sinking Depth & Finish	ok		Counter = 60 Ravi 22	
2	External Relief Dia	4.0 H/c	Outside (2-2)	Inner	
3	External Relief Depth		8 H/c	5 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Porrace		
6	Material Sent For Hardening On Date		6	4	24
Inspected By (Sign) & Date			Ravi 6/4/24		

Reviewed by (Engineer-CNC)

Manager-QA