



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.		11655/	35/40
2	Machined By		V. T. L. n/c Shop	Drg No. 1-2-029567
3	Pallet Die No.		11678 (3-0) H4	Revised
4	Die Category	Drg. No.	590	
5	Out Side Diameter	Drg. No.	499.8 H4 Step 02, 499.7 H4	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	182 H4	
8	Grooves as per Drawing	Drg. No.	10x10x4 H4 10x10x4 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		455 H4	of hole = 2
13	Tapping Hole Diameter		H2 = Check by H2 = Bell	Rotu Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19 H4 Tapping Depth = 16.8 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 9/4/24

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 - Hole Closed

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 H4	Outside (2-2)		Inner				
3	External Relief Depth		11 H4		5 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			9	4	24			

Inspected By (Sign) & Date Ravi 9/4/24

Reviewed by (Engineer-CNC) Sot...

Manager-QA