



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.		9948	30/50/65
2	Machined By		V.T.L N/C Shop	Drg No. 1.8.02 693
3	Pallet Die No.		10369 (3.8) M	Rev 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 M, Step OD 822.8 M	Tapper 4°
6	Inside Diameter	Drg. No.	700.12 M	Step length 33 M
7	Width of Pellet Die	Drg. No.	324 M	
8	Grooves as per Drawing	Drg. No.	30x8x8.4 M / 30x8x8.5 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No of holes 12 Both Side
12	Tapping PCD		760 M	
13	Tapping Hole Diameter		M22 ✓ Check by M22 B.14	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 36.5 M Tapping Depth 34.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/7/23

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							Ravi 46
2	External Relief Dia	4.3 M / 4.8 M	4.3 M	All Lines	4.8 M	All Lines			
3	External Relief Depth		35 M		15 M				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porroce
6	Material Sent For Hardening On Date		28	7	23				

Inspected By (Sign) & Date

Ravi 28/7/23

Reviewed by (Engineer-CNC)

Manager-QA