



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.		12085	L10/L10
2	Machined By		V.T.L n/c Shop	Drg No. 18.02 783
3	Pallet Die No.		11839 (5.0) n/c	Rev 1.0
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c	
6	Inside Diameter	Drg. No.	Step OD 249 n/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No. of Holes, 8 Both Side
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 18.3 n/c	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/2/24

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 Sink
2	External Relief Dia	5.5 n/c	Outside (2-2)	Inner			Rev 1.7
3	External Relief Depth		5 n/c	Nil			
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	7	24		

Inspected By (Sign) & Date

Ravi 9/7/24

Reviewed by (Engineer-CNC)

Manager-QA