



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.		12382	33/40
2	Machined By		V.T.L. H/c Shop	Dry Star last 31.0
3	Pallet Die No.		11589 (3.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 H/c Step 002 395 H/c	Step length 14.5
6	Inside Diameter	Drg. No.	3.20 1.2 H/c	
7	Width of Pellet Die	Drg. No.	14.2 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c / 15.5 x 7 x 2 H/c	
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 28 Both side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		H16. Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.4 H/c, Tapping Depth 19 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/7/24

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 G ^o
2	External Relief Dia	3.5 H/c	outside (2-2)		Inner			
3	External Relief Depth		13 H/c		7 H/c			
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