



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.			
2	Machined By		12413	33/50
3	Pallet Die No.		V.T.L. M/c Shop	Dy No. 12.C.998
4	Die Category	Drg. No.	9878 (3.0) M/C	Res no
5	Out Side Diameter	Drg. No.	Ext 74 wide	
6	Inside Diameter	Drg. No.	620 M/C Step 00, Tapped 12°	
7	Width of Pellet Die	Drg. No.	520.12 M/C	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 M/C 13x8x5 M/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No. of Holes = 12 Back side
13	Tapping Hole Diameter		565 M/C	
14	Tapping On Second Side	Half pitch of 1st side	M/c Check by H/c Ball	
15	Tapping Hole Depth		OK	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Drill Repts. 20.4 M/C	
17	Visual Inspection Before Gun Drilling		yes OK	

Inspected By (Sign) & Date

Sasi 22/8/24

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 20° Len = 38
2	External Relief Dia	3.3 M/C	20 Side 3-3.5	Inner			
3	External Relief Depth		23 M/C	17 M/C			
4	Inspection Done Before Hardening By (Name)			Sasi			
5	Material Sent For Hardening By (Name)			Lark Fornace			
6	Material Sent For Hardening On Date		22	8	24		

Inspected By (Sign) & Date

Sasi 22/8/24

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Reviewed by (Engineer-CNC)

Manager-QA