



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.		12820	42/50
2	Machined By		V.T.L. H/c Shop	Dy. No. G.E.C. 18038
3	Pallet Die No.		12774 (5.0) H/H	Rev. No.
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	420 H/H Step 00. 395 H/H	Step length 1.5
6	Inside Diameter	Drg. No.	320.12 H/H	
7	Width of Pellet Die	Drg. No.	142 H/H	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/H / 15.5 x 7 x 2 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		355 H/H	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/H Tapping Depth = 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/9/24

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 H/H	Outside (2-2)		Inner		Rev 2-14
3	External Relief Depth		13 H/H		8 H/H		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		14	9	24		
Inspected By (Sign) & Date		Ravi 14/9/24					

Reviewed by (Engineer-CNC)

Manager-QA