



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		12936 ✓	33/40 ✓
3	Pallet Die No.		V.T.L M/c Shop	Dy. no. Lark 3570 ✓
4	Die Category	Drg. No.	12738(3.0) H.H. ✓	
5	Out Side Diameter	Drg. No.	38 H.H. ✓	
6	Inside Diameter	Drg. No.	500 H.H. ✓	Step length 17.5 ✓
7	Width of Pellet Die	Drg. No.	420.12 H.H. ✓	
8	Grooves as per Drawing	Drg. No.	188.1 H.H. ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H.H. / 12x8x3 H.H. ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No. of Holes = 8 Both Side
13	Tapping Hole Diameter		454 H.H.	
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt ✓	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.4 H.H. ✓	Tapping Depth = 18.5 ✓
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 30/09/24

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 60°
2	External Relief Dia	3.3 mm	outside	Inner					Row - 30
3	External Relief Depth		(2-2) 18 H.H. ✓	7 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		30	09	24				

Inspected By (Sign) & Date

Ravi 30/09/24

Satya 30/09/24
Reviewed by (Engineer-CNC)

Manager-QA