



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.		13017	50/50
2	Machined By		V.T.L n/c Shop	Dry Hole L.E.Cs 13760
3	Pallet Die No.		13437 (B.O) n/c	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.90 n/c Step 002 4.91 n/c	
6	Inside Diameter	Drg. No.	4.20.12 n/c	Step length = 13.5
7	Width of Pellet Die	Drg. No.	1.58 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 8 Back Side
12	Tapping PCD		4.54 n/c	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 n/c	Tapping Depth = 16.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 16/10/24

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 Rev = 12
2	External Relief Dia	8.5 n/c	outside (2-2)		Inner				
3	External Relief Depth		4 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		16	10	24				

Inspected By (Sign) & Date Ravi 16/10/24

Satyam
16/10/24.
Reviewed by (Engineer-CNC)

Manager-QA