



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.		13091 ✓	40/40 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. L&C-15062
3	Pallet Die No.		12466(5.0) n/c	Rev 2 n/c
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c	
6	Inside Diameter	Drg. No.	Step on 498.88	Tapper = 12
7	Width of Pellet Die	Drg. No.	420.12 n/c	Step length = 18 n/c
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes = 8 Both Side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c = Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.4 n/c	Tapping Depth = 16.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 23/10/24

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								
2	External Relief Dia	5.3 n/c	outside (2.2)		Inner					Rev 2 14
3	External Relief Depth		4 n/c		Mill					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			23	10	24				

Inspected By (Sign) & Date

Ravi 23/10/24

Reviewed by (Engineer-CNC)
 23/10/24

Manager-QA