



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.		13144 13144 ✓	42/50 ✓
2	Machined By		V. T. L. H/C Shop	Dy. No. 1.2.02.980
3	Pallet Die No.		12585 (3.5)	Rev 200 ✓
4	Die Category	Drg. No.	9x2xwide	
5	Out Side Diameter	Drg. No.	6.20 H/H ✓	Step 02 = Tapper = 12°
6	Inside Diameter	Drg. No.	5.20.12 H/H ✓	Step length = 18.5 ✓
7	Width of Pellet Die	Drg. No.	2.22 H/H ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 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 = 12 Both Side
12	Tapping PCD		56.5 H/H ✓	
13	Tapping Hole Diameter		M20 = Check by M20 Ball ✓	
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 11/10/24

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

Counter = 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.0 H/H	Outside (3-3)		Inner					
3	External Relief Depth		15 H/H		8 H/H					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date									11 10 24

Inspected By (Sign) & Date

Ravi 11/10/24

Satish 11/10/24

Reviewed by (Engineer-CNC)

Manager-QA