



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.		13404 ✓	38/55 ✓
2	Machined By		V.T.L n/c Shop	Dr. No. 62.92 ✓
3	Pallet Die No.		13866 (41.0) ✓	Rev 2 ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 ✓, Step 00.699 ✓	Step length ✓
6	Inside Diameter	Drg. No.	600.9 ✓	Tapper 12° ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 ✓ / 12x8x7 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of hole = 12 Both Side
12	Tapping PCD		640 ✓	
13	Tapping Hole Diameter		M202 Check by H2. Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 ✓ Tapping Depth: 18.8 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/11/24

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
Rev = 32

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 ✓	Outside P3-3J		Inner		
3	External Relief Depth	23 ✓		19 ✓			
4	Inspection Done Before Hardening By (Name)		Ravi ✓				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		28	11	24		

Inspected By (Sign) & Date

Ravi 28/11/24

Sat 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA