



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.		13410 ✓	36/40 ✓
2	Machined By		V.T.L H/c Shop	Drg No. 1.1302905
3	Pallet Die No.		12709 (3.0) H/c ✓	Rev. 1.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c ✓	Step 02 = 491 H/c ✓
6	Inside Diameter	Drg. No.	420.12 H/c ✓	Step length 17.5 ✓
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c ✓	12x8x3 H/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c ✓	Tapping H/c of H/c 8 Both Side
13	Tapping Hole Diameter		03/4" ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 18.3 H/c ✓	Tapping Depth, 16.5 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/11/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter = 60 Row = 24
2	External Relief Dia	3.5 H/c ✓	Outside (2-2)		Inner			
3	External Relief Depth		10 H/c ✓		4 H/c ✓			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Porhace			
6	Material Sent For Hardening On Date		30	11	24			

Inspected By (Sign) & Date

Ravi 30/11/24

Satya 21/12/24

Reviewed by (Engineer-CNC)

Manager-QA