



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.		13539	34/40
2	Machined By		V. T. L. M/C Shop	Dy No. (30.11) 46
3	Pallet Die No.		13858 (2.2) 44	Recess
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	385 44 Step 002 382 44	Step length 11.3
6	Inside Diameter	Drg. No.	304.12 44 / 305.12 44 (Recess 305.12)	
7	Width of Pellet Die	Drg. No.	144 44	
8	Grooves as per Drawing	Drg. No.	10484 5 44 / 10480 5 44	ED Maintenance
9	Fitting Sizes on CNC Plate	Drg. No.	ok	final machining
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping dia of holes 8 both side
12	Tapping PCD		350 44	
13	Tapping Hole Diameter		N/C - Check by M/C Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 44 Tapping Depth 18.5 44	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/12/24

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

Count etc 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.1 44	outside (2-2)		Inner				
3	External Relief Depth		12 44		6 44				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		14	12	24				

Inspected By (Sign) & Date

Ravi 14/12/24

Reviewed by (Engineer-CNC)
 Saty 14/12/24

Manager-QA