



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.			
2	Machined By		13433	38/40
3	Pallet Die No.		N.T.L. n/c Shop	Drg No. Lark 58-10
4	Die Category	Drg. No.	13042 (3.5) n/c	
5	Out Side Diameter	Drg. No.	520	
6	Inside Diameter	Drg. No.	500 n/c, Step OD = 491 n/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	182 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes 8
13	Tapping Hole Diameter		454 n/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	M20: Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.3 n/c	Tapping Depth = 16.8
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 11/12/24
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					Counter 80°
2	External Relief Dia	4.0 n/c	outside (2-2)		Inner		Ravi 27
3	External Relief Depth		6 n/c		2 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		11	12	24		

Inspected By (Sign) & Date

[Signature]
12/12/24

Ravi 11/12/24

Reviewed by (Engineer-CNC)

Manager-QA