



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		13679 ✓	40/40 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Drg. Lark 3810
4	Die Category	Drg. No.	12718(5.0) ✓	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/C Step GD = 491 H/C	Step length = 17.5
7	Width of Pellet Die	Drg. No.	420.12 H/C	
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	Tapping No. of holes = 8 Both Side
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.1 H/C	Tapping Depth = 18.5 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raoi 25/12/24

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

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

1	Counter Sinking Depth & Finish	OK						Counter = 60°
2	External Relief Dia	5.5 H/C	Outside (2-2)		Inner			200 x 17
3	External Relief Depth		4 H/C		Will			
4	Inspection Done Before Hardening By (Name)							Raoi
5	Material Sent For Hardening By (Name)							Lark Purvance
6	Material Sent For Hardening On Date		25	12	24			

Inspected By (Sign) & Date

Raoi 25/12/24

Satya 25/12/24

Reviewed by (Engineer-CNC)

Manager-QA