



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.		13673 ✓	50/50 ✓
2	Machined By		V. T. L. H/C Shop	Drg. No. 13890 (8.0) ✓
3	Pallet Die No.		13890 (8.0) ✓	Rev. No. ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52.0 mm ✓	Step length 12.5 ✓
6	Inside Diameter	Drg. No.	42.0 ± 0.12 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm 12 x 8 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 mm ✓	
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 18.2 mm ✓	Tapping Depth 16.5 mm ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/12/24

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 = 6°
2	External Relief Dia	8.5 mm	Outside (2-2)	Inner				Rev = 12
3	External Relief Depth		4 mm	Null				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		27	12	24			

Inspected By (Sign) & Date

Ravi 27/12/24

Sats 27/12/24

Reviewed by (Engineer-CNC)

Manager-QA