



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.		13166 ✓	75/75 ✓
2	Machined By		V. T. L. H/c Shop	Drg No. L.3.0-691
3	Pallet Die No.		14207 (8.0) H/c ✓	Rev 200 ✓
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1061.1 H/c ✓ Step 002 1041 H/c	Tappers 4 ✓
6	Inside Diameter	Drg. No.	✓ 911.12 H/c / 911.9 H/c (Bot = 911.1)	Step length = 29 H/c ✓
7	Width of Pellet Die	Drg. No.	388 H/c ✓	
8	Grooves as per Drawing	Drg. No.	33x9.9x10 H/c / 33x9.8x10 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face side step]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	[Both side]
12	Tapping PCD		975 H/c ✓	
13	Tapping Hole Diameter		H24 = Check by H24 Bolt	of holes = 18
14	Tapping On Second Side	Half pitch of 1st side	ok	Both side ✓
15	Tapping Hole Depth		Drill Depth 40.3 H/c	Tapping Depth 38.3 H/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/1/25

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	9.0 H/c ✓	20 side 2-3 ✓	Innen			Row 30
3	External Relief Depth		8 H/c ✓	Nil ✓			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark For race				
6	Material Sent For Hardening On Date		18	1	25		

Inspected By (Sign) & Date

Ravi 18/1/25

Satyam 18/1/25

Reviewed by (Engineer-CNC)

Manager-QA