



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.		13931 ✓	53/58 ✓
2	Machined By		V.T.L. n/c Shop	Drill Hole 1.201 ✓
3	Pallet Die No.		13274 (3.3) ✓	Raw ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776 ✓ Step 002 200 ✓	Step length 26 ✓
6	Inside Diameter	Drg. No.	660.12 ✓	Wider outer 13 ✓
7	Width of Pellet Die	Drg. No.	316 ✓	
8	Grooves as per Drawing	Drg. No.	20 x 8 x 7.5 ✓ / 20 x 8 x 7.5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping width of hole = 12 Both Side
12	Tapping PCD		725 ✓	
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 25.3 ✓ Tapping Depth 23.6 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/1/25

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 - 3 Hole Colored

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

1	Counter Sinking Depth & Finish	ok					Counter = 6 Rop = 47
2	External Relief Dia	4.3 ✓	outside (3.3)		Inner		
3	External Relief Depth		12 ✓		5 ✓		
4	Inspection Done Before Hardening By (Name)						Ravi ✓
5	Material Sent For Hardening By (Name)						Lark furnace
6	Material Sent For Hardening On Date		20		25		

Inspected By (Sign) & Date

Ravi 20/1/25

Reviewed by (Engineer-CNC)

Manager-QA