



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		13837 ✓	364 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. Lark 3310
4	Die Category	Drg. No.	12360 (3.0) H ✓	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.7 H ✓ Step 0.02 490.7 H ✓	Step length 7.4
7	Width of Pellet Die	Drg. No.	420.12 H ✓	
8	Grooves as per Drawing	Drg. No.	158 H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H ✓ 12x8x3 H ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of holes & Both Side
13	Tapping Hole Diameter		454 H ✓	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.2 H ✓	Tapping Depth 16.0 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 22/1/25

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					Count per 60
2	External Relief Dia	3.3 H ✓	Outside (2-2)	Inner			Count per 24
3	External Relief Depth		10 H ✓	4 H ✓			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		22	1	25		

Inspected By (Sign) & Date

Ravi 22/1/25

Reviewed by (Engineer-CNC)

Manager-QA