

9/03



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		13166 ✓	75/75 ✓
3	Pallet Die No.		V.T.L. N/C Shop	Drg No. 130 ✓
4	Die Category	Drg. No.	14204 (8.0) ✓	Rev. no ✓
5	Out Side Diameter	Drg. No.	S. Jumbo	
6	Inside Diameter	Drg. No.	1061 ✓ Step OD: 1041 ✓	Tappers 4 ✓
7	Width of Pellet Die	Drg. No.	911.3 ✓	Step length 29 ✓
8	Grooves as per Drawing	Drg. No.	388 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	33x10x10 ✓ 33x10x10 ✓	
10	Drilling Area Surface Smoothness		ok	[Face Side Step Inner Deep Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	[Tapping No. of holes. 16 Both Side]
13	Tapping Hole Diameter		975 ✓	
14	Tapping On Second Side	Half pitch of 1st side	M2.4 - Check by H24 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 40.4 ✓	Tapping Depth 38.4 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi: 28/1/25

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		N.

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

Counter, Bo
Low: 30

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	9.0 ✓	outside 3-35				
3	External Relief Depth		8 ✓				
4	Inspection Done Before Hardening By (Name)		Ravi:				
5	Material Sent For Hardening By (Name)		Lark Ferrace				
6	Material Sent For Hardening On Date		28	1	25		

Inspected By (Sign) & Date

Ravi: 28/1/25

Satish
28/1/25

Reviewed by (Engineer-CNC)

Manager-QA