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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.		14033 ✓	36/45 ✓
2	Machined By		V. T. L. n/c Shop	Dry slot 1.2.0.302
3	Pallet Die No.		13128 (B.O) n/c	Rev. 00 ✓
4	Die Category	Drg. No.	3210	
5	Out Side Diameter	Drg. No.	510 n/c, Step 0.02, 491 n/c	Step length 16.5
6	Inside Diameter	Drg. No.	420.12 n/c (Bot = 419.9 n/c)	
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 n/c / 10 x 8.5 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping n/c of Holes & Bolt Side]
12	Tapping PCD		455 n/c ✓	
13	Tapping Hole Diameter		03/16" Check by 03/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 n/c	Tapping Depth 8.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/1/25

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	6.5 n/c	Outside (3.25)		Inner				Rev 17
3	External Relief Depth		15 n/c		9 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fornace
6	Material Sent For Hardening On Date		29	1	25				

Inspected By (Sign) & Date

Ravi 29/1/25

Satyam 29/1/25

Reviewed by (Engineer-CNC)

Manager-QA