



# 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		14071 ✓	50/50 ✓
3	Pallet Die No.		V. T. L. H/C Shop	Dynas 13.02153
4	Die Category	Drg. No.	14063 (8:0) ✓	Rev 2.00 ✓
5	Out Side Diameter	Drg. No.	Senior (AS <sup>2</sup> )	
6	Inside Diameter	Drg. No.	519.9 mm ✓	Step OD = 491 mm ✓
7	Width of Pellet Die	Drg. No.	420.2 mm ✓	Step length 16.5 ✓
8	Grooves as per Drawing	Drg. No.	160 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 9 x 3 mm / 12 x 9 x 3 mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	[ Tapping M of holes. 8 Right Side ]
13	Tapping Hole Diameter		454 mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	03/4" - Check by 03/4" Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 mm ✓	Tapping Depth 18.5 ✓
17	Visual Inspection Before Gun Drilling		yes ok	
Inspected By (Sign) & Date			Ravi 5/2/25	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter 60 Rev 2.12 ✓
2	External Relief Dia	2.5 mm ✓	00 Side (2-2)	Inner
3	External Relief Depth		5 mm	Mill
4	Inspection Done Before Hardening By (Name)		Ravi ✓	
5	Material Sent For Hardening By (Name)		Shri Keshav <del>...</del>	
6	Material Sent For Hardening On Date		5	2
Inspected By (Sign) & Date			Ravi 5/2/25	

Reviewed by (Engineer-CNC)

Manager-QA