



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.		11095	39/50
2	Machined By		V.T.L. H/c Shop	Qty Has bank 35 ✓
3	Pallet Die No.		10526(3.5) H	
4	Die Category	Drg. No.	539TD	
5	Out Side Diameter	Drg. No.	62mm Step OD = 612mm	Step length = 19.5 ✓
6	Inside Diameter	Drg. No.	52.12 mm	
7	Width of Pellet Die	Drg. No.	186mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Rota Side ✓
12	Tapping PCD		565mm	
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 = 21mm Tapping Depth = 19mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/1/24

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 Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	2.8mm	outside (2-3)	inner					
3	External Relief Depth	✓	18mm	11mm					
4	Inspection Done Before Hardening By (Name)		✓	Ravi					
5	Material Sent For Hardening By (Name)			bank furnace					
6	Material Sent For Hardening On Date		11	1	24				

Inspected By (Sign) & Date Ravi 11/1/24

Reviewed by (Engineer-CNC)

Manager-QA