



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.		11004	84/40
2	Machined By		V.T.L. H/C Shop	Drg. No. L-ERC-29109
3	Pallet Die No.		11507 (3.5) H/C	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/C	Step length 14.4
6	Inside Diameter	Drg. No.	320.12 H/C	
7	Width of Pellet Die	Drg. No.	142 H/C	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/C	15.5 x 7 x 2 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of Holes, 8 Rota Side
12	Tapping PCD		355 H/C	
13	Tapping Hole Diameter		H/C Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.5 H/C	Tapping Depth 19 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/11/24

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	3.8 H/C	Outside (2-2)		Inner				
3	External Relief Depth		20 H/C		16 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		12	1	24				

Inspected By (Sign) & Date

Ravi 12/11/24

Reviewed by (Engineer-CNC)
Sachin 12/11/24

Manager-QA