



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.		11186,	26/45,
2	Machined By		V. T. L n/c. Shop	Drg No. 1-3 D2 315
3	Pallet Die No.		11391 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	53570	
5	Out Side Diameter	Drg. No.	610 n/c / Step 002 600.2	n/c Tapping 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	186 n/c	Under cut 6 n/c
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c / 13x8x3 n/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 12 Both Side
12	Tapping PCD		565 n/c	
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 24 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 2/8/24

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

Completed by

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	2.5 n/c	Outside (2-3)		Innen				
3	External Relief Depth	22 n/c			19 n/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			2	2	24			

Inspected By (Sign) & Date

Ravi 2/8/24

Reviewed by (Engineer-CNC)

Manager-QA