



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.		11302	45/50
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.02.870
3	Pallet Die No.		11707 (6.0) n/c	Rev. no.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519 n/c Step OD = 49 n/c	Step length = 19 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	17-5
7	Width of Pellet Die	Drg. No.	159.5 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 13.5x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of Hole = 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0314" - Check by 0314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19 n/c Tapping Depth = 17 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 26/7/24*

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

1	Counter Sinking Depth & Finish	ok					Counter = 80°
2	External Relief Dia	6.5 n/c	Outside (2-2)		Inner		Rev 2-15
3	External Relief Depth		11 n/c		5 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forrage
6	Material Sent For Hardening On Date		26	27	24		

Inspected By (Sign) & Date *Ravi 26/7/24*

Reviewed by (Engineer-CNC) *Satyam 26/7/24*

Manager-QA