



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.		11381	35/40
2	Machined By		V.T.L H/c Shop	Digital 13.0288
3	Pallet Die No.		10991 (3.5) H/c	Revised
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	500 H/c, Step 002, 491 H/c	Step length 18.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/c 10x8.5x5 H/c	
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 8 Both Side
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 H/c Tapping Depth 18.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 4/3/24

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 600

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H/c	Outside (2-2)		Inner				
3	External Relief Depth		9 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark for name
6	Material Sent For Hardening On Date		4	3	24				

Inspected By (Sign) & Date Ravi 4/3/24

Reviewed by (Engineer-CNC) Surya 4/3/24

Manager-QA