



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.		11372	33/46
2	Machined By		V.T.L. n/c Shop	Dry Hole 1.S.D. 975
3	Pallet Die No.		10672 (3.0) n/c	Rev. 100
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410.1 n/c / Step 002 38.3 n/c	Step length 10.4
6	Inside Diameter	Drg. No.	318.1 n/c	
7	Width of Pellet Die	Drg. No.	108.1 n/c	
8	Grooves as per Drawing	Drg. No.	4x5x3 n/c / 4x5x3 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		350 n/c	
13	Tapping Hole Diameter		ø1/2" - Check by ø1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 13 n/c	Tapping Depth 11 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 2/3/24*

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

1	Counter Sinking Depth & Finish	ok						Counter 600
2	External Relief Dia	3.5 n/c	Outside (2-2)		Inner			Rev. 18
3	External Relief Depth		19 n/c		13 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	3	24			

Inspected By (Sign) & Date *Ravi 2/3/24*

Satyam
2/3/24
Reviewed by (Engineer-CNC)

Manager-QA