



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.		11452	41/51
2	Machined By		V.T.L. n/c Shop	Diya Das L.E.O. 10295
3	Pallet Die No.		11420 (3.0) n/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.8 n/c	Step 00. Tapper, 12°
6	Inside Diameter	Drg. No.	58.0-12 n/c	Step length, 33 n/c
7	Width of Pellet Die	Drg. No.	266 n/c	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 n/c	28.5 x 6 x 12 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes, 12° Back Side
12	Tapping PCD		630 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 28 n/c	Tapping Depth 23.2 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/3/24

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 60

1	Counter Sinking Depth & Finish	ok							Rev. 42
2	External Relief Dia	3.5 n/c	outside (3-3)		Inner				
3	External Relief Depth		16 n/c		10 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			12	3	24			

Inspected By (Sign) & Date

Ravi 12/3/24

Reviewed by (Engineer-CNC)

Manager-QA