



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.		11434	39/47
2	Machined By		V.T.L n/c Shop	Dy No. 6.8.2/5431
3	Pallet Die No.		11959 (2.8) 44	Rev 2.00
4	Die Category	Drg. No.	2 side	
5	Out Side Diameter	Drg. No.	614 44, Step 00, 612 44	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12 44	
7	Width of Pellet Die	Drg. No.	322 44	
8	Grooves as per Drawing	Drg. No.	13x8x5 44 13x8x5 44	
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 44	
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 = 20.7 44	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Handwritten signature 18/3/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok A
4	Defective Holes (If Any)		No - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60
 Rev = 40

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.1 44	outside (3-3)		Inner		
3	External Relief Depth		20 44		18 44		
4	Inspection Done Before Hardening By (Name)		Lark Porrace				
5	Material Sent For Hardening By (Name)		Lark Porrace				
6	Material Sent For Hardening On Date		18	3	24		

Inspected By (Sign) & Date

Handwritten signature 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA