



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.		11423 ✓	40/50 ✓
2	Machined By		V. T. L. H/C Shop	Dy. No. 1-8.9.2013
3	Pallet Die No.		11535 (3.5) ✓	Rev. 2.00 ✓
4	Die Category	Drg. No.	Jumbo	ⓐ
5	Out Side Diameter	Drg. No.	7.60 H/C / Step OD = 8.09	Tap hole 10
6	Inside Diameter	Drg. No.	6.60.12 H/C	Step length 130 H/C
7	Width of Pellet Die	Drg. No.	290 H/C	Under cut = 2.2 H/C
8	Grooves as per Drawing	Drg. No.	27.8 x 7.5 H/C 27.8 x 7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of Hole = 12 Body Side
12	Tapping PCD		7.24 H/C	
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30 H/C	Tapping Depth = 27.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 18/3/24	
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 - 12 Hole Released	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		OK	Counter 2.6 Row 43
2	External Relief Dia		4.0 H/C / Outside (3-2)	Inner
3	External Relief Depth		1.7 H/C / 1.0 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forward	
6	Material Sent For Hardening On Date		18 3 24	
Inspected By (Sign) & Date			Ravi 18/3/24	

Reviewed by (Engineer-CNC)
Sakshi 18/3/24

Manager-QA