



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11403/	21/02
2	Machined By		V.T.L. H/C Shop	Drg No. (2.02) 21
3	Pallet Die No.		10971 (2.8) H/C	Rev. 01
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500 H/C / Step OD - 499 H/C	Tappet = 12"
6	Inside Diameter	Dr. No.	420.12 H/C	Step length = 17 H/C
7	Width of Pellet Die	Dr. No.	158 H/C	
8	Grooves as per Drawing	Dr. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		0.314" - Check by 0.314" Ball	Tapping hole of hole = 8 Rota Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19 H/C Tapping Depth = 16.9	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/8/24

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 - 3 Hole (A)

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

Counter 65

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 H/C	20 Side (2.2)		Inner				
3	External Relief Depth		22 H/C		19 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Formed				
6	Material Sent For Hardening On Date			18	3	24			

Inspected By (Sign) & Date

Ravi 18/8/24

Satish 18/8/24

Reviewed by (Engineer-CNC)

Manager-QA