



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.		11497 ✓	28/38/66 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. 12.02.09
3	Pallet Die No.		12041 (6.0) H/c ✓	Rev. 01 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c ✓	Step 00-693 H/c ✓
6	Inside Diameter	Drg. No.	548.12 H/c ✓	Step length 3 H/c ✓
7	Width of Pellet Die	Drg. No.	195 H/c ✓	Width outer 2.5 H/c ✓
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c ✓	32 x 7 x 8 H/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side step 3 H/c ✓
10	Drilling Area Surface Smoothness		OK	Back Side
11	Tapping Operator		H/c Shop	Tapping H/c ✓
12	Tapping PCD		619 H/c	of holes 4 ✓
13	Tapping Hole Diameter		H16 - Check by H16 Ball	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.7 H/c ✓	Tapping Depth 3.2 ✓
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

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

1	Counter Sinking Depth & Finish	OK					Counter 30 ✓
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows	7.0 H/c	All Rows	
3	External Relief Depth			38 H/c		28 H/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		18	3	24		

Inspected By (Sign) & Date

Ravi 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA