



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.		11519	31/40
2	Machined By		V.T.C. n/c Shop	Dry No. 1-8-0215062
3	Pallet Die No.		11882 (3.5) n/c	Rev 200
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500 n/c Step 002 498.88	Tapper 12°
6	Inside Diameter	Dr. No.	420.12 n/c	Step length 13 n/c
7	Width of Pellet Die	Dr. No.	158 n/c	
8	Grooves as per Drawing	Dr. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 2 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 n/c	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 20/3/24

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 60°
2	External Relief Dia	3.8 n/c	outside (2-2)		Inner			
3	External Relief Depth		12 n/c		9 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		20	3	24			

Inspected By (Sign) & Date Ravi 20/3/24

Reviewed by (Engineer-CNC)

Manager-QA