



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.		11519	33/40
2	Machined By		V.T.L. H/c Shop	Dry H/c L & C 13-02
3	Pallet Die No.		11385 (A.5) H	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H H Step 002 498.8 H	Tabber 12°
6	Inside Diameter	Drg. No.	480.14 H	Step length 17.6
7	Width of Pellet Die	Drg. No.	158 H H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H H	
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 holes 8 Both Side
12	Tapping PCD		454 H H	
13	Tapping Hole Diameter		M202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H H	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 21/3/24

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 H H	Outside (2-2)		Inner		Rev 2.00
3	External Relief Depth		10 H H		Fin		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		31	3	24		

Inspected By (Sign) & Date

Rasi 21/3/24

Reviewed by (Engineer-CNC)

Manager-QA