



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.		11516	35/45
2	Machined By		N.C. Shop	Dy. 18.02.24
3	Pallet Die No.		11140 (5.0) H4	Rev. 100
4	Die Category	Drg. No.	SP10	
5	Out Side Diameter	Drg. No.	510 H4 Step 00: 491 H4 Step length	17.4
6	Inside Diameter	Drg. No.	420.1 H4	
7	Width of Pellet Die	Drg. No.	182.1 H4	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N.C. Shop	Tapping Hole of holes on both side
12	Tapping PCD		454 H4	
13	Tapping Hole Diameter		H202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 H4 Tapping Depth 17.4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 29/3/24*

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 Sink
2	External Relief Dia	5.5 H4	20xSide (2-2)	Inner				
3	External Relief Depth		15 H4	10 H4				
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>					
5	Material Sent For Hardening By (Name)		<i>Lark Purvace</i>					
6	Material Sent For Hardening On Date		28	3	24			

Inspected By (Sign) & Date *Ravi 29/3/24*

Saty
Reviewed by (Engineer-CNC)

Manager-QA