



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.			
2	Machined By		11588 ✓	50/50 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Dy H. 2 (18.0) = 415
4	Die Category	Drg. No.	12078 (G.O) H/c ✓	Rev. 01 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 H/c, Step 00, 499 H/c ✓	Tapper 12°
7	Width of Pellet Die	Drg. No.	420.12 H/c ✓	Step length 20 H/c
8	Grooves as per Drawing	Drg. No.	158.1 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	1248+3 H/c / 1248+3 H/c ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		454 H/c ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20 2 Check by M20 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20 H/c	Tapping Depth 17.7
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 27/3/24

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							Count = 60
2	External Relief Dia	6.3 H/c	outside (2-2)		Inner				Low = 15
3	External Relief Depth		4 H/c		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				27	3	24		

Inspected By (Sign) & Date

Ravi 27/3/24

Satyam 27/3/24

Reviewed by (Engineer-CNC)

Manager-QA