



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	33/40
2	Machined By		V.T.L. H/C Shop	Dy. No. 1-2-02 15.09
3	Pallet Die No.		11281 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C Step 00 - 498.8 H/C	Tap 12°
6	Inside Diameter	Drg. No.	420.6 H/C	Step length 21.5
7	Width of Pellet Die	Drg. No.	158.1 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x2.9 H/C 12x8x2.8 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping Ho of Holes - 8 Roth Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 H/C	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/3/24

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 2.60
2	External Relief Dia	3.3 H/C	outside (2-2)	inner				
3	External Relief Depth		13 H/C	7 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		28	3	24			
Inspected By (Sign) & Date			Ravi 28/3/24					

Reviewed by (Engineer-CNC)

Manager-QA