



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.		11523 ✓	120/120
2	Machined By		V.T.G. H/c Shop	Drg No. L.S.O. 559
3	Pallet Die No.		12235 (4.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 H/c ✓	Step 002 743.3 mm Taper 10°
6	Inside Diameter	Drg. No.	630.14 H/c ⓐ	Step length 23
7	Width of Pellet Die	Drg. No.	285 H/c ✓	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c 15x8x5 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 15 Back Side
12	Tapping PCD		685 H/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 21 H/c ✓	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/4/24

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 - 4 Hole Closed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Coarden 600 Low 37
2	External Relief Dia	—	—	No - Relief					
3	External Relief Depth	—	—	—					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Purchase					
6	Material Sent For Hardening On Date			1	4	24			

Inspected By (Sign) & Date Ravi 11/4/24

Reviewed by (Engineer-CNC) Satsa 11/4/24

Manager-QA