



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.		11543	35/43
2	Machined By		V.T.L. n/c Shop	Drig No. (8.22) 1009
3	Pallet Die No.		11752 (5.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	399 n/c Step OD 383 n/c 3rd length n/c	
6	Inside Diameter	Drg. No.	313.12 n/c	
7	Width of Pellet Die	Drg. No.	146 n/c	
8	Grooves as per Drawing	Drg. No.	14x6x3 n/c / 14x6x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes & Both Side
12	Tapping PCD		0.314" = Check by 0.314" Ball	
13	Tapping Hole Diameter		ok	
14	Tapping On Second Side	Half pitch of 1st side	Drill Depth 20.4 n/c Tapping Depth 8.8	
15	Tapping Hole Depth		yes	
16	Perpendicularity of Tapped Hole		ok	
17	Visual Inspection Before Gun Drilling		ok 21/4/24	

Inspected By (Sign) & Date 21/4/24

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

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

1	Counter Sinking Depth & Finish	ok					Counter = 60° Rev = 15
2	External Relief Dia	5.5 n/c	opp side (2.2)		Inner		
3	External Relief Depth		13 n/c		8 n/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			2	4	24	

Inspected By (Sign) & Date 21/4/24

Reviewed by (Engineer-CNC) 21/4/24

Manager-QA