



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.		11612 ✓	U5/45 ✓
2	Machined By		V.T.L n/c Shop	Drg No. 12.9, 868
3	Pallet Die No.		11892 (G.O) n/c	Renoo ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 n/c, Step 00.491 n/c	Step length 18.4 ✓
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	164 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x3 n/c 15x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. of Holes 8 Both side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		031/4" = Check by 031/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 19 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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 G.O
2	External Relief Dia	G. 5 n/c	outside (2-2)	Inner				Pass 15
3	External Relief Depth		6 n/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		2	4	24			

Inspected By (Sign) & Date

Ravi 21/4/24

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

Manager-QA