



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.		11655	35/4
2	Machined By		V.T.L. n/c Shop	Drilling No. 1-5019507
3	Pallet Die No.		11677 (3.0) n/c	Revised
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	499.8 n/c ^(B) step 002 499.7 n/c	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	10x10x4 n/c 10x10x4 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes - 8 Both Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		M20, Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.8 n/c Tapping Depth 16.2 n/c	
16	Perpendicularity of Tapped Hole.		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 9/4/24

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
2	External Relief Dia	3.5 n/c	outside (2-2)	Inner			
3	External Relief Depth		11 n/c	5 n/c			
4	Inspection Done Before Hardening By (Name)		Raw				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		9	4	24		

Inspected By (Sign) & Date

Raw: 9/4/24

Reviewed by (Engineer-CNC)

Manager-QA