



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.		11784	33/50
2	Machined By		V. T. L. n/c Shop	Dry Hole 1.80, 344
3	Pallet Die No.		6285 (3.0) 44	Rev. 00
4	Die Category	Drg. No.	MJEK	
5	Out Side Diameter	Drg. No.	700 44 Step 00, 692 44	Step length 19.5
6	Inside Diameter	Drg. No.	600.14 44	
7	Width of Pellet Die	Drg. No.	265 44	
8	Grooves as per Drawing	Drg. No.	15x8x7 44 15x8x7 44	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes 2 10 Both Side
12	Tapping PCD		640 44	
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: 20.5 44	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 15/4/24

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							
2	External Relief Dia	3.5 44	outside (3-3)		Inner				
3	External Relief Depth		23 44		17 44				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		15	4	24				

Inspected By (Sign) & Date

Raoi 15/4/24

Reviewed by (Engineer-CNC)

Manager-QA