



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.		11890	36/50
2	Machined By		V.T.L. n/c Shop	Qty No. 1.50 218
3	Pallet Die No.		12386(4.5) 44	Rev. 02
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	520 44 Step 002 491 44	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 44	
7	Width of Pellet Die	Drg. No.	182 44	
8	Grooves as per Drawing	Drg. No.	12x8x3 44 / 12x8x3 44	
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		454 44	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 44 Tapping Depth 17 44	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/5/24

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

Counter 260

1	Counter Sinking Depth & Finish	ok																		
2	External Relief Dia	5.0 44	outside (2-2)			Inner														
3	External Relief Depth		18 44			14 44														
4	Inspection Done Before Hardening By (Name)																			
5	Material Sent For Hardening By (Name)																			
6	Material Sent For Hardening On Date																			
Inspected By (Sign) & Date		Ravi 8/5/24																		

Reviewed by (Engineer-CNC)

Manager-QA