



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.		11915	44/50
2	Machined By		V.T.L. n/c Shop	Dry Hole len 3319
3	Pallet Die No.		11651 (4.0) n/c	
4	Die Category	Drg. No.	58810	
5	Out Side Diameter	Drg. No.	6.20 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	5.20.12 n/c	
7	Width of Pellet Die	Drg. No.	1.86 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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, 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		n/c = Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/5/24

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

1	Counter Sinking Depth & Finish	ok					Counter 60°
2	External Relief Dia	4.5 n/c	30 side (13-3)	Inner			
3	External Relief Depth		14 n/c	6 n/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Home
6	Material Sent For Hardening On Date		10	5	24		

Inspected By (Sign) & Date

Ravi 10/5/24

Reviewed by (Engineer-CNC)

Manager-QA