



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.		11724 ✓	38/5 ✓
2	Machined By		V.T.L. H/c. Shop	Dy. H/c. L.E.C. 9980
3	Pallet Die No.		12068 (3-3) ✓	Rev. 2 ✓
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620.1 ✓ / Step 002	Tapper 12° Step 18 ✓
6	Inside Diameter	Drg. No.	520.5 ✓ / 520.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x4 ✓ / 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c. Shop	Tapping of Hole 12 Rota Side
12	Tapping PCD		565 ✓	
13	Tapping Hole Diameter		H20 ✓ Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 ✓	Tapping Depth 18.8 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/5/24	
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 Rev. 2 38
2	External Relief Dia	3.5 ✓	Outside (3-3)	Inner
3	External Relief Depth		18 ✓	18 ✓
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11 5 24	
Inspected By (Sign) & Date			Ravi 11/5/24	

Reviewed by (Engineer-CNC) Satya 11/5/24

Manager-QA