



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.		11947	42/50
2	Machined By		V.T.L. H/C Shop	Dy. Insp. L.E.C. 9980
3	Pallet Die No.		12123 (4.0) H/C	Rev. 2.00
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	620 H/C Step 0.2 Tappet 12° Step length 18 H/C	
6	Inside Diameter	Drg. No.	520.14 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of holes 12° Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 H/C Tapping Depth 18.8 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/5/24

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 = 63° Rev 2.31
2	External Relief Dia	4.5 H/C	60 Side (3-3)		Inner			
3	External Relief Depth		11 H/C		7 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		14	5	24			

Inspected By (Sign) & Date

Ravi 14/5/24

S. J. 14/5/24

Reviewed by (Engineer-CNC)

Manager-QA