



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.		11987	40/55
2	Machined By		V. T. L. H/C Shop	Dy. No. 1.2.0, 355
3	Pallet Die No.		12156(2.8) H/C	
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	630 H/C	Step 002 612 H/C
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 100 H/C
7	Width of Pellet Die	Drg. No.	186 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/C	13x8x3 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tabbing of Holes = 12
13	Tapping Hole Diameter		H20 = Check by H20 Bull	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 H/C	Tabbing Depth = 18.8
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							
2	External Relief Dia	4.3 H/C	Outside (3-3)		Inner				
3	External Relief Depth		18 H/C		15 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

Reviewed by (Engineer-CNC)

Manager-QA