



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.		11912	
2	Machined By		V. T. L. N/C Shop	
3	Pallet Die No.		11756 (3.0) H	Original L. 3.0 574
4	Die Category	Drg. No.	Junior	Rev. 00
5	Out Side Diameter	Drg. No.	385 H	
6	Inside Diameter	Drg. No.	305.12 H	Step length 9.5
7	Width of Pellet Die	Drg. No.	137 H	
8	Grooves as per Drawing	Drg. No.	8x6x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		350 H	Tapping N of Holes = 8 Both Side
13	Tapping Hole Diameter		M12 - Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.1 H	Tapping Depth 16.7 H
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 = 60
2	External Relief Dia	3.5 H	outside (2.2)		Inner			Row 2 do
3	External Relief Depth		6 H		Will			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Parpore			
6	Material Sent For Hardening On Date		14	5	24			

Inspected By (Sign) & Date

Ravi 14/5/24

Sato 14/5/24

Reviewed by (Engineer-CNC)

Manager-QA