



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.		11911 ✓	40/40
2	Machined By		V. T. L. H/c Shop	Dy. No. L.S.D. 977
3	Pallet Die No.		11813 (4.0) ✓	Ren. of ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c ✓ Step OD: 492 H/c	Step length 13.5 ✓
6	Inside Diameter	Drg. No.	420.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	152 H/c ✓	
8	Grooves as per Drawing	Drg. No.	11x5x3 H/c 11x5x3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping no. of Holes 8 Botu Side
12	Tapping PCD		456 H/c ✓	
13	Tapping Hole Diameter		0314" ✓ Check by 0314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 17 H/c Tapping Depth 15.8 H/c ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/5/24

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							Coorden 60° Ravi 21
2	External Relief Dia	4.5 H/c ✓	outside (2-2)	Inner					
3	External Relief Depth		4 H/c	Null					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	5	24				
Inspected By (Sign) & Date								Ravi 13/5/24	

Reviewed by (Engineer-CNC)

Manager-QA