



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.		11976	L1/50
2	Machined By		V.T.L n/c Shop	Drg No. L-2-G-12-501
3	Pallet Die No.		12409 (3.8) n/c	Rev. 01
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c, 3/16 00, 692.8 n/c	Tappet: 12
6	Inside Diameter	Drg. No.	300.12 n/c	Step length: 2 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		n/c	
14	Tapping On Second Side	Half pitch of 1st side	Check by H2 Bolt ok	
15	Tapping Hole Depth		Drill Depth: 20.8 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/5/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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 Row: 33
2	External Relief Dia	U.S n/c	Outside (3.3)	Inner				
3	External Relief Depth		14 n/c	10 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Purana					
6	Material Sent For Hardening On Date		20	5	24			

Inspected By (Sign) & Date

Ravi 20/5/24

Satyam
20/5/24

Reviewed by (Engineer-CNC)

Manager-QA