



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.		13486 ✓	50/50
2	Machined By		V.T.L. N/c Shop	Drg No. 13.02.405
3	Pallet Die No.		10302 (6.0) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 ✓ Step 002 499 ✓	Tapper 12"
6	Inside Diameter	Drg. No.	420.12 ✓	Step length 7"
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	1248 x 3 ✓ 1248 x 3 ✓	
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 8 Both Side
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		024" - Check by 024" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 ✓	Tapping Depth = 8.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/12/24

1	As per programme no.		_____	Final Fitting Size Drg No. 13.02 403 Revers
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

Counters 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 ✓	outside (2-2)		Inner				
3	External Relief Depth		5 ✓		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi ✓				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			4	12	24			

Inspected By (Sign) & Date

Ravi 4/12/24

Satyam 4/12/24

Reviewed by (Engineer-CNC)

Manager-QA