



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.		12983	43/50
2	Machined By		V. T. L. H/c Shop	Dy. No. (2.02) 2614
3	Pallet Die No.		12002 (3.5) H/c	Rev. 2.00
4	Die Category	Drg. No.	M7620	
5	Out Side Diameter	Drg. No.	700 H/c	
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	265 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 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		640 H/c	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		M20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 30.4 H/c	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/07/24

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 - 1 Hole Closed

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter 60
 Rev. 43

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0 H/c	Outside (3-3)	Inner			
3	External Relief Depth	15 H/c		8 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		7	10	24		

Inspected By (Sign) & Date

Ravi 11/07/24

10/7/24

Reviewed by (Engineer-CNC)

Manager-QA