



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13090 ✓	46/50 ✓
2	Machined By		V.T.L. n/c Shop	Dy. No. 125013760
3	Pallet Die No.		13438(8.0) ✓	Rev 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52 ✓	Step length = 17.5
6	Inside Diameter	Drg. No.	42.12 ✓	
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes. 8 Rota Side
12	Tapping PCD		454 ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20.2 Check by M20 Bolt ✓ ok	
15	Tapping Hole Depth		Drill Depth 18.4 ✓	Tapping Depth = 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rawi 23/10/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								Rev = 12
2	External Relief Dia	8.5 ✓	Outside (2-2)		Inner					
3	External Relief Depth		12 ✓		4 ✓					
4	Inspection Done Before Hardening By (Name)									Rawi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		23	10	24					

Inspected By (Sign) & Date

Rawi 23/10/24

Reviewed by (Engineer-CNC)

Manager-QA