



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.		13079 ✓	40/50/70 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. 1.8.0-377
3	Pallet Die No.		12934(8.0) ✓	Rev: 03 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.8 ✓ Step 00.697.8 ✓	Tapper: 5 ✓
6	Inside Diameter	Drg. No.	546.1 ✓ Bor: 548.1 ✓	Step length: 28.5 ✓
7	Width of Pellet Die	Drg. No.	215 ✓	Under cut: 2.18 ✓
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 ✓ / 29.5 x 10 x 8 ✓	(6 x 8) ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side Step 1.44 Deep Bore Side]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		618 ✓	[Tapping No of holes: 2 Bore Side]
13	Tapping Hole Diameter		M16: Check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 32.4 ✓	Tapping Depth: 30.2 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 28/10/24

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		

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

Counter = 30
Row = 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5 ✓ 9.0 ✓	8.5 ✓	All Rows: 30 ✓			
3	External Relief Depth		9.0 ✓	All Rows: 20 ✓			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		28	10	24		

Inspected By (Sign) & Date

Ravi: 28/10/24

Reviewed by (Engineer-CNC)
Sety: 28/10/24

Manager-QA