



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.		13079 ✓	40/50/70
2	Machined By		V.T.L. n/c Shop	Dy. No. 130.377
3	Pallet Die No.		13346 (8.0) ✓	Row 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 ✓	Step OD: 697.8 ✓
6	Inside Diameter	Drg. No.	548.12 ✓	Step length: 38.5 ✓
7	Width of Pellet Die	Drg. No.	215 ✓	Under cut: 1.8 ✓
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 ✓	(8 x 8) ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face side Step ✓
11	Tapping Operator		n/c Shop	Deep Bottom side ✓
12	Tapping PCD		618 ✓	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	Tapping No. of Holes: 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Bottom side ✓
15	Tapping Hole Depth		Drill Rep. No. 32.6 ✓	Tapping Depth: 32.4 ✓
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)		No

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

Counter 90°

1	Counter Sinking Depth & Finish	OK						Row 12
2	External Relief Dia	8.5 ✓	9.0 ✓	8.5 ✓	Row 2	30 ✓		
3	External Relief Depth	✓		9.0 ✓	Row 3	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

28/10/24

Reviewed by (Engineer-CNC)

Manager-QA