



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.		12840	60/66
2	Machined By		V.T.L. N/A Shop	Drill No. 12809/136
3	Pallet Die No.		13515 (3.5) H4	Rev 2.01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 H4	Step 002 1033 H4
6	Inside Diameter	Drg. No.	900.12 H4	Tabber 3
7	Width of Pellet Die	Drg. No.	375 H4	Step length 37mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H4 / 29.5 x 8 x 13 H4	Under cut 0.5 H4
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		970 H4	Tapping No of holes 15 Both Side
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 38.4 H4	Tapping Depth: 36.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/11/24

1	As per programme no.			2 slot 32.1 H4 width 7.5 H4 Depth Both Side
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								Ravi 259
2	External Relief Dia	4.0 H4	Outside (4-4)		Inner					
3	External Relief Depth		13 H4		6 H4					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		6	11	24					

Inspected By (Sign) & Date

Ravi 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA