



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.		13285 ✓	40/40
2	Machined By		V.T.L. n/c Shop	Dy. n/c Test 13285
3	Pallet Die No.		12696 (4.0) n/c ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c 1 Step 002 491 n/c	Step length 17.3
6	Inside Diameter	Drg. No.	4.2012 n/c ✓	
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes, & Both Side
12	Tapping PCD		454 n/c ✓	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/11/24

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°
Ravi 9/11/24

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.3 n/c	outside (2-2)	Inner			
3	External Relief Depth		4 n/c	will			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		9	11	24		

Inspected By (Sign) & Date

Ravi 9/11/24

Reviewed by (Engineer-CNC)

Manager-QA