



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.		13213 ✓	35/40 ✓
2	Machined By		V. T. G. H/c Shop	Dry Hole Lat 16.95 ✓
3	Pallet Die No.		12690 (4.0) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c ✓	Step length = 17.4 ✓
6	Inside Diameter	Drg. No.	420.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c 12 x 8 x 3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes = 8 Both Side
12	Tapping PCD		454 H/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 = 18.3 H/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 ✓

1	Counter Sinking Depth & Finish	OK						Ravi 20 ✓
2	External Relief Dia	4.5 H/c	Outside (2-2)		Inner			
3	External Relief Depth		9 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi ✓
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		a		11		24	

Inspected By (Sign) & Date

Ravi 9/11/24

Satyam 9/11/24
Reviewed by (Engineer-CNC)

Manager-QA