



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.		13135	40/50
2	Machined By		V.T.L. N/C Shop	Drg No. 1.302 1172
3	Pallet Die No.		12562(4.0) H	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H	Step 0.2 693 H Tapper. 12
6	Inside Diameter	Drg. No.	600.12 H	Step length. 2 H
7	Width of Pellet Die	Drg. No.	221.7 H	
8	Grooves as per Drawing	Drg. No.	12x8x5 H / 12x8.7x5 H	
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 - 12 Back Side
12	Tapping PCD		640 H	
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. 20.4 H	Tapping Depth. 8.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/11/24

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
Row - 32

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	4.5 H	Outside (3-3)	Inner		
3	External Relief Depth		14 H	10 H		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		4	11	24	

Inspected By (Sign) & Date

Ravi 4/11/24

4/11/24

Reviewed by (Engineer-CNC)

Manager-QA