



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.		13400 ✓	415/50 ✓
2	Machined By		V.T.C H/c Shop	Dy H., 1-3.0 = 751
3	Pallet Die No.		13455 (6.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/c Step 00 = 498.88	Tapper. 12"
6	Inside Diameter	Drg. No.	420.12 H/c	Step length. 18"
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 No. 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. 16.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/11/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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							
2	External Relief Dia	6.5 H/c	90 Side (2-2)		Inner				
3	External Relief Depth		1 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		27		"	24			

Inspected By (Sign) & Date

Ravi 29/11/24

Reviewed by (Engineer-CNC)
 29/11/24

Manager-QA