



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	45/60
2	Machined By		V.T.L. n/c Shop	Dy No. 12.02-174
3	Pallet Die No.		13368 (8.0) n/c	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 n/c Step 00. 693 n/c	Step length 20 n/c
6	Inside Diameter	Drg. No.	600.4 n/c	Tapper 12 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x5 n/c 12x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes = 10 Both Side
12	Tapping PCD		640 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 20.4 n/c Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/12/24

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 18
2	External Relief Dia	8.5 n/c	outside (3-3)		inner				
3	External Relief Depth		23 n/c		15 n/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		3	12	24				

Inspected By (Sign) & Date

Ravi 31/12/24

Satya 31/12/24
Reviewed by (Engineer-CNC)

Manager-QA