



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.		13498	30/50
2	Machined By		N.T.L H/c Shop	Drg No. 13.9.0.459
3	Pallet Die No.		13474(3.0) H/c	Row 200
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	620 H/c, Step OD = 624.5 H/c	Tappet = 12
6	Inside Diameter	Drg. No.	520.12 H/c	Step length = 20 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut = 2.25 H/c
8	Grooves as per Drawing	Drg. No.	12x8x7 H/c / 12x8x7 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 = 12 Both Side
12	Tapping PCD		565 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 = 20.4 H/c	Tapping Depth = 18.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/12/24

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter = 60
2	External Relief Dia	3.5 H/c	outside (3-3)		Inner			Row 139
3	External Relief Depth		23 H/c		20 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		6	12	24			

Inspected By (Sign) & Date

Ravi 6/12/24

Reviewed by (Engineer-CNC)

Manager-QA