



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.		13457	40/55
2	Machined By		V.T.L. H/c Shop	Dy. No. 1-2-2903
3	Pallet Die No.		13891 (5.0)	Rev. No.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530 H/c	Step 00, 498.8 H/c
6	Inside Diameter	Drg. No.	480.12 H/c	Tabless 2"
7	Width of Pellet Die	Drg. No.	158 H/c	Step length 8"
8	Grooves as per Drawing	Drg. No.	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	
12	Tapping PCD		454 H/c	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/12/24

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 Coloured

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

Counter 60
Row 17

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.5 H/c	Outside (2-2)		Inner		
3	External Relief Depth		20 H/c		15 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		4	12	24		

Inspected By (Sign) & Date

Ravi 4/12/24

Sats 4/12/24

Reviewed by (Engineer-CNC)

Manager-QA