



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.		13548 ✓	26/50/65
2	Machined By		V.T.L. n/c Shop	Days No. 13/12/24
3	Pallet Die No.		13822 (4.0) n/c	Rev 100 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 n/c	Step length 29.5
6	Inside Diameter	Drg. No.	66012 n/c	Undercut 1 n/c
7	Width of Pellet Die	Drg. No.	324 n/c ✓	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 n/c ✓	Tapping H. of hole = 10 Both Side
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 31 n/c	Tapping Depth 28.7 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/12/24

1	As per programme no.			2 slot 32.1 n/c width 8 n/c Depth Both Side
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

Counter: 60°
Rev: 47

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c	All Rows = 99 n/c				
3	External Relief Depth		5.0 n/c	All Rows = 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			13	12	24		

Inspected By (Sign) & Date

Ravi 13/12/24

Reviewed by (Engineer-CNC)
Satyam
14/12/24

Manager-QA