



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

8845

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13667	35/55
3	Pallet Die No.		V.T.L H/C Shop	Drg No. 13.0.666
4	Die Category	Drg. No.	14140(4.0) H/C	Rev. 00
5	Out Side Diameter	Drg. No.	M. Tambo	
6	Inside Diameter	Drg. No.	710 H/C Step 00 - 693 H/C	Step length 20 H/C
7	Width of Pellet Die	Drg. No.	800.12 H/C	Tapper 12°
8	Grooves as per Drawing	Drg. No.	222 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 H/C / 12x10x7.5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	[Tapping No of holes 12 Both Side]
13	Tapping Hole Diameter		640 H/C	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 H/C Tapping Depth 18.6 H/C	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 28/12/24

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 (A)

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

Counter 60°
Row 31

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/C	Outside (2-3)	Inner			
3	External Relief Depth		24 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		26	12	24		

Inspected By (Sign) & Date

Ravi 28/12/24

Setu 26/12/24

Reviewed by (Engineer-CNC)

Manager-QA