



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.		13706 ✓	38/45/55 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. 13.02.48
3	Pallet Die No.		14137 (4.0) H/c ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	710 H/c	Step OD = 692 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Step length = 19.5
7	Width of Pellet Die	Drg. No.	228 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c / 12.5 x 8 x 7 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		645 H/c ✓	Tapping No. of holes, 12 Back 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 22.2 H/c	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/12/24

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	4.5 H/c / 5.0 H/c	4.5 H/c	All Rows	219 H/c ✓			Row 132
3	External Relief Depth		5.0 H/c	All Rows	210 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		27	12	24			

Inspected By (Sign) & Date

Ravi 27/12/24

Reviewed by (Engineer-CNC)

Manager-QA