



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.		13707 ✓	32/50/8752
2	Machined By		N.T.L. H/c Shop	Dy. H/c Lark 8752
3	Pallet Die No.		13056 (8.8) H/c	
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	619.8 H/c ✓ Step 002 611.8 H/c	Step length 219.5
6	Inside Diameter	Drg. No.	520.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	186 H/c ✓	
8	Grooves as per Drawing	Drg. No.	13x8r 5 H/c / 13x8r 5 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		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 H/c Tapping Depth: 18.6 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		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

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	3.1 H/c	outside (2-3)	inner			
3	External Relief Depth		2.9 H/c	1.8 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Purpore				
6	Material Sent For Hardening On Date		28	12	24		

Inspected By (Sign) & Date

Ravi 28/12/24

Reviewed by (Engineer-CNC)

Manager-QA