



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.		13929 ✓	40/48/55 ✓
2	Machined By		V.T.L. H/c Shop	Dr. No. 18.20.666
3	Pallet Die No.		14098 (B.O) H/c	Rev. 200 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	609.9 H/c	Step 00. 692.8 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Tappet. 12 ✓
7	Width of Pellet Die	Drg. No.	999 H/c	Step length. 2.4 ✓
8	Grooves as per Drawing	Drg. No.	12x8x7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7.5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		640 H/c	Tapping H. of holes. 12 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 = 20.2 H/c	Tapping Depth. 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/1/25

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

1	Counter Sinking Depth & Finish	ok						Counter = 60 ✓
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows	2.15 H/c	✓		Row 2 22 ✓
3	External Relief Depth		7.0 H/c	All Rows	2.7 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		16	1	25			

Inspected By (Sign) & Date

Ravi 16/1/25

Sats 16/1/25

Reviewed by (Engineer-CNC)

Manager-QA