



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.		13622 ✓	36/54/78 ✓	
2	Machined By		V. T. L. H/c Shop	Drilled 13.02.2013	
3	Pallet Die No.		13614 (B-5) H/c ✓	Rev-01	
4	Die Category	Drg. No.	M. Tomba		
5	Out Side Diameter	Drg. No.	G36 H/c / G32 H/c Step OD 69.5 H/c / 543 H/c		
6	Inside Diameter	Drg. No.	480.1 H/c / 489.1 H/c / 500.12 H/c	Step length 28 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	18.5 H/c	
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 H/c / 27 x 12 x 8 x 9.5 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 = 4	
12	Tapping PCD		540 H/c ✓		
13	Tapping Hole Diameter		MIG-2 Check by MIG Bolt		
14	Tapping On Second Side	Half pitch of 1st side	Ok. Side Tapping and Top Side One Slot		
15	Tapping Hole Depth		Drill Depth = 28.3 H/c	Tapping Depth = 28.5 H/c	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 18/1/25	1 Slot	
1	As per programme no.		—	28.1 H/c width 17 H/c Deep	
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 20 Rows 9	
2	External Relief Dia	1.0 H/c / 1.5 H/c	1.0 H/c All Rows = 42 H/c		
3	External Relief Depth		1.5 H/c All Rows = 214 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		18	1	25
Inspected By (Sign) & Date			Ravi 18/1/25		

Satish 18/1/25

Reviewed by (Engineer-CNC)

Manager-QA