



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.		13910	34/50
2	Machined By		V.T.L. M/C Shop	Digital 6.8.2013
3	Pallet Die No.		13550 (2.8) M/C	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	750 M/C Step OD = 693 M/C	Step length = 18.6 M/C
6	Inside Diameter	Drg. No.	600.12 M/C	
7	Width of Pellet Die	Drg. No.	220 M/C	
8	Grooves as per Drawing	Drg. No.	9.5 x 10 x 6 M/C / 9.5 x 10 x 6 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of holes, 12 Both side
12	Tapping PCD		645 M/C	
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 = 22.3 M/C Tapping Depth = 26 M/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/1/25

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.3 M/C	Outside (2-3)		Inner					
3	External Relief Depth		22 M/C		16 M/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

Reviewed by (Engineer-CNC)

Manager-QA