



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.		13940 ✓	32/42/60 ✓
2	Machined By		V.T.L N/C Shop	Drg No. 1392854
3	Pallet Die No.		14145 (6.0) ✓	Rev. = 002 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	719.9 mm ✓	Step 00.6919 mm ✓
6	Inside Diameter	Drg. No.	600.12 mm ✓	Step length 19.4 ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	36x10x7 mm ✓	36x10x7 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		645 mm ✓	Tapping No. of Holes = 12 Roh. 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 20.2 mm	Tapping Depth 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/1/25

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° Rov = 16
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm	All Rows = 22 mm ✓				
3	External Relief Depth		7.0 mm	All Rows = 12 mm ✓				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		20	1	25			

Inspected By (Sign) & Date

Ravi 20/1/25

Satish 20/1/25

Reviewed by (Engineer-CNC)

Manager-QA