



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)

9041

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13166 ✓	75/75 ✓
2	Machined By		V.T.L. H/c Shop	Dry No. 130-891
3	Pallet Die No.		14206 (8.0) H/c	Rev 2.00 ✓
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1061 H/c, Step 0.02 1041 H/c	Tapper 4"
6	Inside Diameter	Drg. No.	911.12 H/c 911.2 H/c ⊙	Step length 25 H/c
7	Width of Pellet Die	Drg. No.	388 H/c	
8	Grooves as per Drawing	Drg. No.	33x9.8x10 H/c 33x9.9x10 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Fore Side Step
10	Drilling Area Surface Smoothness		ok	1 H/c Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No.
12	Tapping PCD		975 H/c	of Holes 16
13	Tapping Hole Diameter		H24 ✓ Check by H24 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 40.3 H/c	Tapping Depth 38.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/1/25

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 2 Go
2	External Relief Dia	9.0 H/c	outside (3-3)		Inner			Rev 3.0
3	External Relief Depth		8 H/c		Mill			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	1	25			

Inspected By (Sign) & Date

Ravi 22/1/25

Satish 22/1/25

Reviewed by (Engineer-CNC)

Manager-QA