



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)

4035

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14045 ✓	39/50 ✓
2	Machined By		V.T.L. n/c Shop	Dy No. 1-2-029980
3	Pallet Die No.		13727 (3.0) mm ✓	Rev 200 ✓
4	Die Category	Drg. No.	Endside ✓	
5	Out Side Diameter	Drg. No.	62mm, Step OD = Tapper, 12° ✓	
6	Inside Diameter	Drg. No.	520.12 mm ✓	Step length 18.5 ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping W. of hole = 12 Bolt Side
12	Tapping PCD		565 mm ✓	
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 = 20.3 mm Tapping Depth = 18.5 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/1/25

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 ✓ Rev 28 ✓
2	External Relief Dia	3.3 mm	outside (3-3)		Inner					
3	External Relief Depth		17 mm		11 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		21	1	25					

Inspected By (Sign) & Date

Ravi 31/1/25

Reviewed by (Engineer-CNC)

Manager-QA