



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)

9048

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13837 ✓	36/40 ✓
2	Machined By		V.T.L. n/c Shop	3175 Dy. n/c Lark 3170
3	Pallet Die No.		12356 (3.0) n/c ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.7 n/c ✓	Step OD: 490.7 n/c ✓
6	Inside Diameter	Drg. No.	420.12 n/c ✓	Step length: 17.4 ✓
7	Width of Pellet Die	Drg. No.	158 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c ✓	12x8x3 n/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c ✓	Tapping H of holes: 8 Both 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: 18.2 n/c ✓	Tapping Depth: 16.6 n/c ✓
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

Count on: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 n/c ✓	outside (2-2)		inner				
3	External Relief Depth		10 n/c ✓		4 n/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		22		25				

Inspected By (Sign) & Date

Ravi 22/1/25

Saty 22/1/25

Reviewed by (Engineer-CNC)

Manager-QA