



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14004	36/55
2	Machined By		V. T.L. H/O Shop	Drilling No. 1.3.0 407
3	Pallet Die No.		14099 (4.0) H/O	Rev. No.
4	Die Category	Drg. No.	H-Jumbo	
5	Out Side Diameter	Drg. No.	70 H/O Shop 00, 393 H/O	Step length 2mm
6	Inside Diameter	Drg. No.	600.12 H/O	Tabber 12"
7	Width of Pellet Die	Drg. No.	222 H/O	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 H/O / 12 x 8 x 7 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		640 H/O	Tapping No of Holes 12 Botu Side
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 18.2 H/O Tapping Depth 16.6 H/O	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/1/25

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
2	External Relief Dia	4.5 H/O	Outside 23-35		Inner		Botu 3d
3	External Relief Depth		23 H/O		19 H/O		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		28		25		

Inspected By (Sign) & Date

Ravi 28/1/25

Reviewed by (Engineer-CNC)

Manager-QA