



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)

9/28

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13940 ✓	37/47/60
2	Machined By		V.T.L. H/c Shop	Drilling No. 68.0.654
3	Pallet Die No.		14146 (6.0) H/c	Rev. 00
4	Die Category	Drg. No.	H. Tomba	
5	Out Side Diameter	Drg. No.	7.20 H/c	
6	Inside Diameter	Drg. No.	Sd ch 002 692 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	6.00.12 H/c	
8	Grooves as per Drawing	Drg. No.	2.2.2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	36x10x7 H/c 36x10x7 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of holes 12 Both Side
13	Tapping Hole Diameter		6.45 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by Hex Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 H/c	Tapping Depth 18.6 H/c
17	Visual Inspection Before Gun Drilling		Yes 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

Counter G
Row-16

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows = 23 H/c		
3	External Relief Depth		7.0 H/c	All Rows = 13 H/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		31	1	25	

Inspected By (Sign) & Date

Ravi 31/1/25

31/1/25

Reviewed by (Engineer-CNC)

Manager-QA