



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

9185

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14058	60/66
2	Machined By		V.T.L. H/c Shop	Dy. No. 12.2.609
3	Pallet Die No.		14031 (12.0) H/c	Reo. 03
4	Die Category	Drg. No.	M. Tembo	
5	Out Side Diameter	Drg. No.	680.7 H/c	Step OD: 692.8 H/c
6	Inside Diameter	Drg. No.	546.12 H/c (Reo. 548.4 H/c)	Step length: 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step 2 H/c Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	Tapping No. of Holes: 2 Both Side
13	Tapping Hole Diameter		M16	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33.3 H/c	Tapping Depth: 31.5 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/2/25

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 60
Row 6

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	12.0 H/c	All	Row 5			
3	External Relief Depth			6 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		13	2	25		

Inspected By (Sign) & Date

Ravi 13/2/25

Satyam
13/2/25

Reviewed by (Engineer-CNC)

Manager-QA