



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14098 ✓	30/66 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. 1.2.0 ✓ 320
3	Pallet Die No.		14388 (8.0) ✓	Rev 08 ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 ✓ Step 00.8 ✓ 2.2 ✓	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 ✓ (Box: 548.12 ✓)	Step length 21 ✓
7	Width of Pellet Die	Drg. No.	195 ✓	Under cut 2.8 ✓
8	Grooves as per Drawing	Drg. No.	32x7x9.1 ✓ 32x7x9.1 ✓	(4x8) ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step
11	Tapping Operator		n/c Shop	2mm Deep Back side
12	Tapping PCD		619 ✓	
13	Tapping Hole Diameter		N16: Check by N16 Bolt	Tapping No. of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back side
15	Tapping Hole Depth		Drill Depth: 33.3 ✓ Tapping Depth: 31.6 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 15/2/25

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

1	Counter Sinking Depth & Finish	ok						Counter: 30
2	External Relief Dia	9.0 ✓		All Rows				Row: 10
3	External Relief Depth			36 ✓				
4	Inspection Done Before Hardening By (Name)			Raw:				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		15	2	25			

Inspected By (Sign) & Date

Raw: 15/2/25

Reviewed by (Engineer-CNC)

Manager-QA