



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)

9654

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14707	38/48/78
2	Machined By		V. T. L. H/O Shop	Drill H. 1.20
3	Pallet Die No.		14215 (B.O) H/O	Row 02
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	636 H/O / 632 H/O - Step OD. 630.3 H/O	
6	Inside Diameter	Drg. No.	480.12 H/O / 489.12 H/O / 500.12 H/O	Step length 28 H/O 18.5 H/O
7	Width of Pellet Die	Drg. No.	182 H/O	
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 H/O / 27 x 12 x 8 x 9.5 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		540 H/O	
13	Tapping Hole Diameter		H/O Check by wig Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1st Side One Side	
15	Tapping Hole Depth		Drill Depth 28.4 H/O Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Row: 18/4/25

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 27.5

1	Counter Sinking Depth & Finish	OK							Row: 10
2	External Relief Dia	6.5 H/O / 7.0 H/O	6.5 H/O All Rows - 40 H/O						
3	External Relief Depth		7.0 H/O All Rows 230 H/O						
4	Inspection Done Before Hardening By (Name)		Row:						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		18	4	25				

Inspected By (Sign) & Date

Row: 18/4/25

Reviewed by (Engineer-CNC)

Manager-QA