



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)

9720

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14791	28/4/55
2	Machined By		V. T. L. Shop	Dr. H. 12.0.407
3	Pallet Die No.		14234 (4.0) H4	Rev. 0
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.8 H4	Step 02. G93 H4
6	Inside Diameter	Drg. No.	600.12 H4	Tabber 12
7	Width of Pellet Die	Drg. No.	222 H4	Step length 2 H4
8	Grooves as per Drawing	Drg. No.	12x8x7 H4 12x8x7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C. Shop	
12	Tapping PCD		640 H4	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H4	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rev. 25/4/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter 60
2	External Relief Dia	4.6 H4 5.0 H4	4.6 H4 All Rows 2 27 H4	Row 2 32
3	External Relief Depth		5.0 H4 All Rows 2 15 H4	
4	Inspection Done Before Hardening By (Name)		Rev.	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25 4 25	
Inspected By (Sign) & Date			Rev. 25/4/25	

Reviewed by (Engineer-CNC)

Manager-QA