



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.		11300	27/35/55
2	Machined By		V.T.L. n/c Shop	Dy. No. 13.0.4.07
3	Pallet Die No.		11898 (5-0) n/c	Rev. No.
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c Step 002 892.8 n/c Tapper 12	
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 19.8
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c / 12 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		840 n/c	
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 221.4 n/c Tapping Depth 13.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pass: 14/8/24

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

1	Counter Sinking Depth & Finish	OK						Pass: 25
2	External Relief Dia	5.5 n/c / 6.0 n/c	5.5 n/c All Rows	6.0 n/c All Rows				
3	External Relief Depth	✓	28 n/c	20 n/c				
4	Inspection Done Before Hardening By (Name)		Pass:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		14	2	24			

Inspected By (Sign) & Date

Pass: 14/8/24

Reviewed by (Engineer-CNC)

Manager-QA