



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11454	34/45/55
2	Machined By		M.T.L. H/c Shop	Drg No. I.S.O. 480
3	Pallet Die No.		12135 (4.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/c Step 002 698 H/c	Step length = 19.5
6	Inside Diameter	Drg. No.	600.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c / 12.5 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		645 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 22.7 H/c	Tapping Depth = 22.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/3/24

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

1	Counter Sinking Depth & Finish	OK					Counter = 60° Rows = 32
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c All Rows	5.0 H/c All Rows			
3	External Relief Depth		21 H/c	10 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		18	3	24		

Inspected By (Sign) & Date

Ravi 18/3/24

Reviewed by (Engineer-CNC)

Manager-QA