



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.		11648	40/48/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1-20-266
3	Pallet Die No.		12138 (G.2) n/c	Rev 2.00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c, Step OD, 692.8 n/c	Tapping 12
6	Inside Diameter	Drg. No.	600.14 n/c	Step length 2 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c / 12x10x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes, 12 Bore side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		n/c, Check by n/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 20.8 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/24

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 6
2	External Relief Dia	6.5 n/c / 1.0 n/c	6.5 n/c All Rows	1.0 n/c All Rows		Rev 2.00
3	External Relief Depth		15 n/c	7 n/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		2	4	24	

Inspected By (Sign) & Date

Ravi 21/7/24

Reviewed by (Engineer-CNC)
Sotya 21/7/24

Manager-QA