



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.		13658	37/50
2	Machined By		V.T.L. H/O Shop	Dy. No. 125-1
3	Pallet Die No.		12875(30)H	Raw 201
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H	Step 60, 693 H
6	Inside Diameter	Drg. No.	600.12 H	Tappet 12
7	Width of Pellet Die	Drg. No.	222 H	Step length 20
8	Grooves as per Drawing	Drg. No.	12x 8x 7 H / 12x 8x 7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		640 H	
13	Tapping Hole Diameter		H2 = Check by Hex Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/1/25

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 20

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H	outside (3-3)		inner					
3	External Relief Depth		17 H		13 H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date		14	1	25					

Inspected By (Sign) & Date

Ravi 14/1/25

Reviewed by (Engineer-CNC)

Manager-QA