



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.			
2	Machined By		13825 ✓	28/66 ✓
3	Pallet Die No.		V.T.L H/c Shop	Dy. No. 12.9 26.9
4	Die Category	Drg. No.	14004 (G.O) H/c	Rev 203
5	Out Side Diameter	Drg. No.	M-Tumbo	
6	Inside Diameter	Drg. No.	680.7 H/c Step OD = 693 H/c	Tappers 3"
7	Width of Pellet Die	Drg. No.	546.12 H/c (Bor = 548.34)	Step length 1.3 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Inter cut = 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 H/c / 32 x 7 x 9.2 H/c (4 x 3) H/c	
10	Drilling Area Surface Smoothness		ok	[Face side Step 9 H/c Deep Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	[Tapping No. of Holes = 2 Both Side]
13	Tapping Hole Diameter		619 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H16 Check by H16 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 33.3 H/c	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 17/1/25

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

Count error 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	1.0 H/c	All Rows						Row 12
3	External Relief Depth		40 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		17	1	25				

Inspected By (Sign) & Date

Ravi 17/1/25

Reviewed by (Engineer-CNC)

Manager-QA