



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.		14034	36/45
2	Machined By		V.T.L. H/c Shop	Dy No. L-30, 579
3	Pallet Die No.		13829(3.0) H/c	Revol
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	610 H/c	Step OD, 615.5 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 20 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut 2.75
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes - 12 Both side
12	Tapping PCD		565 H/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 20.3 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/1/25

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

1	Counter Sinking Depth & Finish	ok							Counter = 60
2	External Relief Dia	3.5 H/c	Outside (3.3)		Inner				Rav 2 38
3	External Relief Depth		15 H/c		9 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Resource
6	Material Sent For Hardening On Date		22		25				

Inspected By (Sign) & Date

Ravi 22/1/25

Reviewed by (Engineer-CNC)

Manager-QA