



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.		14369	4.6/55
2	Machined By		V. T. L. H/C Shop	Driller 6.8.02347
3	Pallet Die No.		13589 (4.0) H/C	Revol
4	Die Category	Drg. No.	Endrenside	
5	Out Side Diameter	Drg. No.	630 H/C Step 00, 623 H/C	Tapper 12"
6	Inside Diameter	Drg. No.	520.14 H/C	Step length 2"
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 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 No. of Holes 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20.12 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H/C	Tapping Depth 186
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ques: 18/3/25

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

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1	Counter Sinking Depth & Finish	OK						Page 31
2	External Relief Dia	4.5mm	Outside 3-3		Inner			
3	External Relief Depth		19mm		15mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Porre					
6	Material Sent For Hardening On Date		18	3	25			

Inspected By (Sign) & Date

8a: 18/3/25

Reviewed by (Engineer-CNC)

Manager-QA