

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)

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14380	30/50
2 Machined By		V.T.I. H/C Shop	Qty No. 120-9980
3 Pallet Die No.		14284 (13.0) H/C	Rev. No.
4 Die Category	Drg. No.	Extrude	
5 Out Side Diameter	Drg. No.	620 H/C Step on Tapper 12°	
6 Inside Diameter	Drg. No.	520.12 H/C	Step length 185
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
12 Tapping PCD		565 H/C	Both Side
13 Tapping Hole Diameter		H202 Check by H20 Bolt	
14 Tapping On Second Side	Half pitch of 1st side	OK	
15 Tapping Hole Depth		Drill Depth 20.2 H/C Tapping Depth 185	
16 Perpendicularity of Tapped Hole		Yes	
17 Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date		Ravi 22/3/25	
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			
1 Counter Sinking Depth & Finish	OK		Counter Sinking
2 External Relief Dia	3.5 H/C	Outside (3-3)	Inner
3 External Relief Depth		23 H/C	20 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		22 3 25	
Inspected By (Sign) & Date		Ravi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA