



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.		14345 ✓	55/86
2	Machined By		V.T.L. H/c Shop	Dy. No. 12.03.69
3	Pallet Die No.		14504 (8.0) H/c	Rev. 03 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c, Step 002 693 H/c	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 H/c (Per: 548.4 H/c)	Step length 21 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c 32.7 x 9.2 H/c (4x8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	✓ Race Side Step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep Bot
11	Tapping Operator		H/c Shop	Side
12	Tapping PCD		619 H/c	✓ Tapping H/c
13	Tapping Hole Diameter		H/G 2 Check by H/G Bolt	of H/c 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bot Side
15	Tapping Hole Depth		Drill Depth 33.2 H/c	✓ Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/3/25

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

Counters 30

1	Counter Sinking Depth & Finish	ok						Repele
2	External Relief Dia	9.0 H/c	All Rows					
3	External Relief Depth		11 H/c					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Purnore					
6	Material Sent For Hardening On Date		13	3	25			

Inspected By (Sign) & Date

Ravi 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA