



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	55/66
2	Machined By		V. G. L. H/c Shop	Dr. G. L. B. 609
3	Pallet Die No.		14505 (8.0) H/c	80003
4	Die Category	Drg. No.	M. Jumba	
5	Out Side Diameter	Drg. No.	680.7 H/c	Step 0.0. 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Bos. 548 H/c) Step length 3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 8.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/c	32 x 7 x 9.2 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Race Side Step
10	Drilling Area Surface Smoothness		ok	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		NIG - Check by NIG Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both 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

1	Counter Sin'ing Depth & Finish	ok								Co. order 630
2	External Relief Dia	9.0 H/c		All Rows						Row 10
3	External Relief Depth			11 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			13	3	25				

Inspected By (Sign) & Date

Ravi 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA