

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.		14428	28/38/66
2	Machined By		V.T.L H/c Shop	Dr No. 12.02.09
3	Pallet Die No.		14745 (G.O) H/c	Rev 203
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	320.7 H/c	Step 00. 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Undercut = 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/c	(4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		319 H/c	Tapping H/c
13	Tapping Hole Diameter		M16.2 Check by M16 Bolt	of holes & Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.2 H/c	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/3/25	
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 230
2	External Relief Dia	6.5 H/c	All Rows 2 28 H/c	Row = 12
3	External Relief Depth	7.0 H/c	All Rows 2 28 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 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA