



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

9287

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14813	35/40
2	Machined By		V.T.L. H/C Shop	Dy. H. 1.25.15-062
3	Pallet Die No.		14683 (3.2) H/C	Revision
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C	Step 00 = 498.88
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 18 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C	12x8x3 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 3/5/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60
2	External Relief Dia	3.8 H/C	Outside 22.2	Inner
3	External Relief Depth		11 H/C	5 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		3 5 25	
Inspected By (Sign) & Date			Ravi 3/5/25	

Reviewed by (Engineer-CNC)

Manager-QA