



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.		14923	45/50
2	Machined By		V.T.C. H/c Shop	Dr. H. L. G. C. 10/9/89
3	Pallet Die No.		14549(3.5) H/c	Rev 201
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H/c, Step 001 792 H/c	Step length 97
6	Inside Diameter	Drg. No.	660.14 H/c	Order cut 16 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21x8x10 H/c / 21x8x10 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		725 H/c	
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 27.3 H/c	Tapping Depth 25.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/5/25	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	4.0 H/c	Outside (3-3)	Inner
3	External Relief Depth		12 H/c	5 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Perrance	
6	Material Sent For Hardening On Date		13	5
Inspected By (Sign) & Date			Ravi 13/5/25	

Reviewed by (Engineer-CNC)

Manager-QA