



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)

4882

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14860	28/38/60
2	Machined By		V. T. G. H/O Shop	Dry No. 18.0, 3-9
3	Pallet Die No.		15016 (B.O) H/O	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/O, Step OD, 693 H/O	Tapper 8
6	Inside Diameter	Drg. No.	546.12 H/O, (Box = 548.4 H/O)	Step length 31 H/O
7	Width of Pellet Die	Drg. No.	195 H/O	Under cut = 2.5 H/O
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/O, 32 x 7 x 9.2 H/O (4 x 2) H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side 32 x 7
10	Drilling Area Surface Smoothness		OK	9 H/O Deep Bottom
11	Tapping Operator		H/O Shop	Side
12	Tapping PCD		619 H/O	Tapping H/O
13	Tapping Hole Diameter		HIG. Check by HIG Ball	of holes = 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth = 33.4 H/O	Tapping Depth = 3.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/5/25

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

Counter 30

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H/O, 7.0 H/O	6.5 H/O	All Rows 28					
3	External Relief Depth		7.0 H/O	All Rows 28					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Pune					
6	Material Sent For Hardening On Date		16	5	25				

Inspected By (Sign) & Date

Ravi 16/5/25

Reviewed by (Engineer-CNC)

Manager-QA