



Lark Engineering Company (India) Pvt. Ltd.

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

9885

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.		14996	GA/GG
2	Machined By		V. T. L. H/c Shop	Dry H/c 12.0.20
3	Pallet Die No.		15153 (12.0) H/c	Removal
4	Die Category	Drg. No.	N. J. 100 h/c	
5	Out Side Diameter	Drg. No.	680.1 H/c Shop 00.693 H/c	Tabber 8
6	Inside Diameter	Drg. No.	546.12 H/c (Bor. 548.1 H/c)	Step length 12.3 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/c / 32.7 x 9.1 H/c	(Check)
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		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H/c - Check by H/c Ball	of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 39.4 H/c	Tapping Depth 31.6 H/c
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				
1	Counter Sinking Depth & Finish	ok		Counter 6
2	External Relief Dia		no - Relief	
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnore	
6	Material Sent For Hardening On Date		16 5 25	
Inspected By (Sign) & Date			Ravi 16/5/25	

Reviewed by (Engineer-CNC)

Manager-QA