



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FIN/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

Sl. No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14891	34/40
2	Machined By		V. T. L. H/c Shop	Dr. U. L. E. G. 10
3	Pallet Die No.		15189 (3.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm Step 00-395 H/c	Step length 14.5
6	Inside Diameter	Drg. No.	32.14 H/c	
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c	15.5 x 7 x 2 (Carve Side cut)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(A)
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		H/c Check by H/c Bolt	Tapping H/c of hole 2 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 H/c	Tapping Depth 18 H/c
16	Perpendicularity of Tapped Hole		1.23	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 24/5/25	
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 Sink Ravi 25
2	External Relief Dia	3.3 H/c	Outside (2.25)	Inner
3	External Relief Depth		12 H/c	Grey
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Process	
6	Material Sent For Hardening On Date		24	5 25
Inspected By (Sign) & Date			Ravi 24/5/25	

Reviewed by (Engineer-CNC)

Manager-QA