



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.		14740	60/66
2	Machined By		V. T. L. H/C Shop	Dr. H. B. S. 9/36
3	Pallet Die No.		15570 (3.5) H/C	Rev. 01
4	Die Category	Drg. No.	S. Tumbo	
5	Out Side Diameter	Drg. No.	1032.2 H/C Step 02	1033 H/C Tapper 3°
6	Inside Diameter	Drg. No.	900.2 H/C / 900.6 H/C (B)	Step length 37 H/C
7	Width of Pellet Die	Drg. No.	375 H/C	Under cut 0.5 H/C
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H/C	29.5 x 8 x 13 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		970 H/C	
13	Tapping Hole Diameter		H24	Tapping H/C of hole 1.5
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 38.4 H/C	Tapping Depth 38.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 28/5/25	2 S.I. t
1	As per programme no.			32.1 H/C width
2	Gun Drilling Work Completed On			7.5 H/C Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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 60
2	External Relief Dia	4.0 H/C	Outside 2.5-4	Raw: 59
3	External Relief Depth		13 H/C	Inner 6 H/C
4	Inspection Done Before Hardening By (Name)		Raw:	
5	Material Sent For Hardening By (Name)		Lark Raware	
6	Material Sent For Hardening On Date		28 5 25	
Inspected By (Sign) & Date			Raw: 28/5/25	

Reviewed by (Engineer-CNC)

Manager-QA