



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.		14997	25/40/60
2	Machined By		V. T. L. H/c Shop	Dry H. 19.0.1397
3	Pallet Die No.		13645(B.O) H/c	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	819.8 H/c Step 00. 802.7 H/c	Tapper. 125
6	Inside Diameter	Drg. No.	750.14 H/c	Step length. 43 H/c
7	Width of Pellet Die	Drg. No.	340 H/c	
8	Grooves as per Drawing	Drg. No.	37x8x12 H/c 37x8x12 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		742 H/c	
13	Tapping Hole Diameter		H/c. Check by H/c Gols	Tapping H/c of hole. 10 Bedu Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 25.4 H/c	Tapping Depth. 23.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Raw: 30/5/25	
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. 60 Raw. 38
2	External Relief Dia	6.5 H/c 1.0 H/c	6.5 H/c	All Rows, 35 H/c
3	External Relief Depth		1.0 H/c	All Rows, 30 H/c
4	Inspection Done Before Hardening By (Name)		Raw:	
5	Material Sent For Hardening By (Name)		Lark Burner	
6	Material Sent For Hardening On Date		30	5 25
Inspected By (Sign) & Date			Raw: 30/5/25	

Reviewed by (Engineer-CNC)

Manager-QA