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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15106	58/66
2	Machined By		V.T.C. H/C Shop	Dr H. 12.0.32
3	Pallet Die No.		15218(9.0) H/C	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	4+3
5	Out Side Diameter	Drg. No.	880.1 H/C Step 00 = 698 H/C	Tappet. 8"
6	Inside Diameter	Drg. No.	546.12 H/C (Box - 548.2 H/C)	Step length 3"
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut = 2.8 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/C 32 x 7 x 9.1 H/C (4 x 8) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/C Shop	2nd Deep Bore Side
12	Tapping PCD		619 H/C	Tapping H/C
13	Tapping Hole Diameter		H16	Check by H16 Bolt
14	Tapping On Second Side	Half pitch of 1st side	OK	of holes id Bore Side
15	Tapping Hole Depth		Drill Depth 33.5 H/C	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/6/25

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 60

1	Counter Sinking Depth & Finish	OK						Rev. 8
2	External Relief Dia	10.0 H/C		All Rops				
3	External Relief Depth			8 H/C				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		9	6	25			

Inspected By (Sign) & Date

Ravi 9/6/25

Reviewed by (Engineer-CNC)

Manager-QA