



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15189	45/60
2	Machined By		V.T.L. n/c Shop	Dr. H. 12.0. 345
3	Pallet Die No.		15757 (8.0) n/c	Rev 2.00
4	Die Category	Drg. No.	780 n/c	
5	Out Side Diameter	Drg. No.	780 n/c	Step 00. 798 n/c
6	Inside Diameter	Drg. No.	660.14 n/c	Tap hole 4
7	Width of Pellet Die	Drg. No.	324 n/c	Step length = 25.5
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 n/c	Mod. ext. = 90
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		n/c. Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 30.4 n/c	Tapping Depth. 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 16/6/25	
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				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	8.5 n/c	8.5 side	Inner
3	External Relief Depth		23 n/c	15 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		16 6 25	
Inspected By (Sign) & Date			Ravi 16/6/25	

Reviewed by (Engineer-CNC)

Manager-QA