



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.		15189	45/60
2	Machined By		V. T. L. H/C Shop	Drg. No. 02.02.1343
3	Pallet Die No.		15636 (8.0)	Rev. on
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm Step on 798mm	Tapper 4
6	Inside Diameter	Drg. No.	660.14mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut 9mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7mm / 21.5 x 8 x 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 = Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4mm Tapping Depth = 28.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/6/25	
1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			32.1mm width
3	Hole Finish In Gun Drilling	Marked	ok	8mm Deep
4	Defective Holes (If Any)		No	Both Side
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				Counter = 60
1	Counter Sinking Depth & Finish	ok		Rev. 27
2	External Relief Dia	8.5mm	Outside (3-3)	Inner
3	External Relief Depth		23mm	15mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purpore	
6	Material Sent For Hardening On Date		19 6 25	
Inspected By (Sign) & Date			Ravi 19/6/25	

Reviewed by (Engineer-CNC)

Manager-QA