



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. 72 H/C Shop	Dy No. 12.0.13/13
3	Pallet Die No.		15760 (8.0) H/C	Ren. 100
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/C	Step 02: 798 H/C
6	Inside Diameter	Drg. No.	660.14 H/C	Tabber: 40
7	Width of Pellet Die	Drg. No.	324 H/C	Step length: 25.5
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 H/C	Under cut = 9 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 7 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		785 H/C	Tapping H/C of holes 12
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 30.5 H/C	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	2 Side
1	As per programme no.			32.1 H/C width
2	Gun Drilling Work Completed On			Both Side
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	8.5 H/C	23.1 H/C	Row: 28
3	External Relief Depth		15 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		19 6 25	
Inspected By (Sign) & Date			Ravi 19/6/25	

Reviewed by (Engineer-CNC)

Manager-QA