

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)

10189

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15351	98/40
2	Machined By		V. T. L. H/c Shop	Qty 400 (200 = 201)
3	Pallet Die No.		15173 (2.5) H/c	Revol
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step 00 = 499 H/c	Tapping 12
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12-8 x 3 H/c / 12-8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping 12
12	Tapping PCD		454 H/c	of holes 2
13	Tapping Hole Diameter		031/4" = Check by 031/4" Ball	Side Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 H/c	Tapping Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/7/25	
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		Count er. 60
2	External Relief Dia	3.0 H/c	008 side (2.2)	Low 2.28
3	External Relief Depth		18 H/c	12 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		2 7 25	
Inspected By (Sign) & Date			Ravi 21/7/25	

Satish 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA