

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.		15431	30/66
2	Machined By		V. T. L. H/c Shop	Day 11. 12.2 39
3	Pallet Die No.		15544 (8.0) H/c	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 00. 692.8 H/c
6	Inside Diameter	Drg. No.	548.14 H/c	Step length = 31
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.8
8	Grooves as per Drawing	Drg. No.	32x7x9.1 H/c	32x7x9.1 H/c (4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side 8
10	Drilling Area Surface Smoothness		OK	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		M16 Check by M16 Bolt	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth. 33.4 H/c	Tapping Depth. 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Soni 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		Counter, 60
2	External Relief Dia	7.0 H/c	All Rows	Row 12
3	External Relief Depth		36 H/c	
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Burnace	
6	Material Sent For Hardening On Date		21 7 25	
Inspected By (Sign) & Date			Soni 21/7/25	

Reviewed by (Engineer-CNC)

Manager-QA