



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)

10358

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15464	58/66
2	Machined By		V. T. L. H/c Shop	Qty. 12.0.30
3	Pallet Die No.		15540 (9.0) H/c	Row 08
4	Die Category	Drg. No.	H. T. L. H/c	Row 08
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 05. 692.8 H/c
6	Inside Diameter	Drg. No.	546.14 H/c (Bore = 548.2) H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Width cut = 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/c 32.7 x 9.1 H/c	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side step
10	Drilling Area Surface Smoothness		OK	2 H/c Depth
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H16 = Check by H16 Bolt	of Hole. 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth. 33.7 H/c	Tapping Depth. 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/7/25

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

Counter 60
Row 8

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	10.0 H/c	All Rows				
3	External Relief Depth		8 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		24	7	25		

Inspected By (Sign) & Date

Ravi 24/7/25

Reviewed by (Engineer-CNC)

Manager-QA