



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.		15630	35/06
2	Machined By		V. J. H/c Shop	Dry run 12.0.39
3	Pallet Die No.		15556(G.O) H/c	Review
4	Die Category	Drg. No.	H. Jumbo	Review
5	Out Side Diameter	Drg. No.	680.2 H/c	Step 06. 692.8 H/c
6	Inside Diameter	Drg. No.	546.14 H/c	Step 06. 548.2 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	Order cut 2.2 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 H/c	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/c Shop	2 H/c Deep
12	Tapping PCD		619 H/c	Both Side
13	Tapping Hole Diameter		H/c 2 Check by H/c Bolt	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	OK	of Hole 2
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Both Side
16	Perpendicularity of Tapped Hole		Yes	Tapping Depth 31.0
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rawl 26/7/25	
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 = 30
2	External Relief Dia	11.0 H/c	All Rops	Row = 12
3	External Relief Depth		31 H/c	
4	Inspection Done Before Hardening By (Name)		Rawl	
5	Material Sent For Hardening By (Name)		Lark Burnage	
6	Material Sent For Hardening On Date		26 7 25	
Inspected By (Sign) & Date			Rawl 26/7/25	

Satya 26/7/25

Reviewed by (Engineer-CNC)

Manager-QA