

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10459

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.		15251	6.166
2	Machined By		V.T.L. H/c. Shop	Dy. H/c. 136
3	Pallet Die No.		16197 (B.5)	Revol
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 H/c. Step 002	1033 H/c. Tapper. 3
6	Inside Diameter	Drg. No.	900.14 H/c.	Step length 37
7	Width of Pellet Die	Drg. No.	375 H/c.	Under cut 0.5
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H/c.	29.5 x 8 x 13 H/c.
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c. Shop	Tapping H/c.
12	Tapping PCD		970 H/c.	of hole. 15
13	Tapping Hole Diameter		M242 Check by M24 B.11	Both Side.
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.4 H/c.	Tapping Depth 358
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 12/8/25	2 Slot
1	As per programme no.			32.1 H/c. width
2	Gun Drilling Work Completed On			7.5 H/c. Depth
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 260
2	External Relief Dia	4.0 H/c.	Outside 4.5	Rev. 59
3	External Relief Depth		13 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		12 8 25	
Inspected By (Sign) & Date			Ravi 12/8/25	

Satyam
12/8/25

Reviewed by (Engineer-CNC)

Manager-QA