



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)

10524

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15751	40/55
2	Machined By		V. T. L. H/c. Shop	Drill 12.0 G.3
3	Pallet Die No.		16314 (6.0) H/c	Revised
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	629.9 H/c	Step 00.623.8 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 12 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 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		565 H/c	of H/c 12
13	Tapping Hole Diameter		H200 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 H/c	Tapping Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 25/8/25	
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		6.5 H/c	Outside (2-3) 21 H/c
3	External Relief Depth			Inner 15 H/c
4	Inspection Done Before Hardening By (Name)			Ravi
5	Material Sent For Hardening By (Name)			Lark Porrace
6	Material Sent For Hardening On Date		25	8 25
Inspected By (Sign) & Date			Ravi 25/8/25	

Reviewed by (Engineer-CNC)

Manager-QA