



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.		16042	38/50
2	Machined By		V.T.I. M/c Shop	Dry No. 1-5-9980
3	Pallet Die No.		15695(3-5) H-H	Rev 200
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 H-H	Step OD 2 Tapper 2 12°
6	Inside Diameter	Drg. No.	520.14 H-H	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H-H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H-H / 13x8x5 H-H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 H-H	of Hole 2 12
13	Tapping Hole Diameter		H20 = Check by H20 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 H-H	tapping depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi	20/9/25
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	4.0 H-H	outside 3-37	Row = 35
3	External Relief Depth		19 H-H	12 H-H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		20 9 25	
Inspected By (Sign) & Date			Ravi	20/9/25

Reviewed by (Engineer-CNC)

Manager-QA