



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.		18094	80/60
2	Machined By		V.T.I. H/c Shop	Dry No = 18.0144
3	Pallet Die No.		15903 (5.0) H/c	Rev 100
4	Die Category	Drg. No.	Ext. wide	
5	Out Side Diameter	Drg. No.	840 H/c	Step OD = 611.9 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length = 81.5
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 No
12	Tapping PCD		565 H/c	of Holes = 12
13	Tapping Hole Diameter		H20 Check by H20 B.11	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 H/c	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/9/25	
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	5.5 H/c	Out Side (3-3)	Row = 28
3	External Relief Depth		5 H/c	N:11
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		23 9 25	
Inspected By (Sign) & Date			Ravi 23-9-25	

Reviewed by (Engineer-CNC)

Manager-QA