



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.		15984	32/45/55
2	Machined By		V.T.I. M/c Shop	Dray No. L.S.D. 407
3	Pallet Die No.		15485(4.0)H	Rev. 2.00
4	Die Category	Drg. No.	M. 70mm	
5	Out Side Diameter	Drg. No.	709.9H	Step OD = 692.8H
6	Inside Diameter	Drg. No.	300.14H	Taper 12°
7	Width of Pellet Die	Drg. No.	222H	Step length 20
8	Grooves as per Drawing	Drg. No.	12x8x7H / 12x8x7H	
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		640H	of Holes 212
13	Tapping Hole Diameter		12mm Check by 42-Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5H	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi	25-9-25
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	4.6mm / 5.0mm	4.6mm All Rows = 83mm	Row 39
3	External Relief Depth		5.0mm All Rows = 10mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25 9 25	
Inspected By (Sign) & Date			Ravi	25-9-25

Reviewed by (Engineer-CNC)

Manager-QA