

Lark Engineering Company (India) Pvt. Ltd.

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

10764

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.			
2	Machined By		15575	75/75
3	Pallet Die No.		V.7 B. H/c Shop	Dy. 12.06.91
4	Die Category	Drg. No.	16450 (80) H/c	Rev. 02
5	Out Side Diameter	Drg. No.	S. Jumbo	
6	Inside Diameter	Drg. No.	1060.9 H/c	Step 00. 1040.9 H/c
7	Width of Pellet Die	Drg. No.	911.1 H/c	Step length 29 H/c
8	Grooves as per Drawing	Drg. No.	388 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	33x10x10 H/c	33x10x10 H/c
10	Drilling Area Surface Smoothness		ok	Face side Step
11	Tapping Operator		ok	Inner Deep Part
12	Tapping PCD		H/c Shop	Side
13	Tapping Hole Diameter		974.9 H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H24. Check by H24 Bolt	of Holes. 16
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 40 H/c	Tapping Depth 27.8
17	Visual Inspection Before Gun Drilling		Yes	
			ok	
Inspected By (Sign) & Date			Ravi 29/9/25	
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	
2	External Relief Dia		9.0 H/c	Outside 2-35
3	External Relief Depth		8 H/c	Inner Null
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29	9 25
Inspected By (Sign) & Date			Ravi 29/9/25	

Satya 29/9/25

Reviewed by (Engineer-CNC)

Manager-QA