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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.		14714	36/50/65
2	Machined By		V.T.L. H/c Shop	18.0.917
3	Pallet Die No.		14060 (4.0) H/c	Rev: 00
4	Die Category	Drg. No.	June	
5	Out Side Diameter	Drg. No.	790 H/c Step 00. 792 H/c Step length 90.5	
6	Inside Diameter	Drg. No.	260.12 H/c	Undercut - 1 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 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 of holes 12 Both Side
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 31.4 H/c Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/4/25	28104
1	As per programme no.			32.1 H/c H/c 8 H/c Drill Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 1 Hole Closed	
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	4.5 H/c / 5.0 H/c	4.5 H/c All Rows ~ 29 H/c	Row 2 42
3	External Relief Depth		5.0 H/c All Rows ~ 15 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		22 4 25	
Inspected By (Sign) & Date			Ravi 22/4/25	

Reviewed by (Engineer-CNC)

Manager-QA