



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)

9870

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14903	30/50
2	Machined By		V.T.L. H/c Shop	Drg No. 12.0.578
3	Pallet Die No.		14713(3.0) H/c	Revol
4	Die Category	Drg. No.	9x12x10 side	
5	Out Side Diameter	Drg. No.	619.8 H/c	Step on 615.4 H/c
6	Inside Diameter	Drg. No.	52.14 H/c	Step length to 20 H/c
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 H/c
12	Tapping PCD		565 H/c	of H/c 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/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/5/25	
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 38
2	External Relief Dia	3.3 H/c	Outside 3.3	Inner
3	External Relief Depth		28 H/c	20 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		15	5
Inspected By (Sign) & Date			Ravi 15/5/25	

Satish 15/5/25

Reviewed by (Engineer-CNC)

Manager-QA