



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.		14803	36/55
2	Machined By		V. T. L. H/c Shop	By 12.0.12/15
3	Pallet Die No.		15526(4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Turn bo	
5	Out Side Diameter	Drg. No.	785 H/c 2 step 00. 814 H/c / 805.5 H/c	
6	Inside Diameter	Drg. No.	675 H/c / 675.12 H/c	Step length 60.5 H/c
7	Width of Pellet Die	Drg. No.	407 H/c	Under cot. 14.5 H/c
8	Grooves as per Drawing	Drg. No.	50.5 x 9 x 7 H/c / 50.5 x 9 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		730 H/c	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Tapping H/c of hole 21
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 40.3 H/c	Tapping Depth 38.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/5/25	2 Slot
1	As per programme no.			30.1 H/c wired
2	Gun Drilling Work Completed On			40 H/c Deep
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
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		Countdown 60
2	External Relief Dia	4.5 H/c	outside (3-3)	Low 51
3	External Relief Depth		21 H/c	19 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	Total width APPROVED
5	Material Sent For Hardening By (Name)		Lark Furnace	BY
6	Material Sent For Hardening On Date		19 5 25	Management
Inspected By (Sign) & Date			Ravi 19/5/25	Sales.

Reviewed by (Engineer-CNC)

Manager-QA