



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		14952	27/66
2	Machined By		V. T. L. n/c Shop	Dr. 4. 692.39
3	Pallet Die No.		15152 (6.0) n/c	Rev. 08
4	Die Category	Drg. No.	N. J. 10. 10	
5	Out Side Diameter	Drg. No.	680.1 n/c Step 00. 698 n/c	Tapping 8"
6	Inside Diameter	Drg. No.	546.12 n/c (Bore 548.2) n/c	Step length 0. 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Width 0. 2. 8 n/c
8	Grooves as per Drawing	Drg. No.	32. 7. 9. 1 n/c 32. 7. 9. 1 n/c	(4. 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 3. 4
10	Drilling Area Surface Smoothness		ok	2 n/c Deep
11	Tapping Operator		n/c Shop	Bottom Side
12	Tapping PCD		619 n/c	Tapping 1. 4
13	Tapping Hole Diameter		NIB - Check by NIB Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bottom Side
15	Tapping Hole Depth		Drill Depth. 33.4 n/c	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

22/5/25

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 30
2	External Relief Dia	1.0 n/c		All Rows						Rev. 12
3	External Relief Depth			39 n/c						
4	Inspection Done Before Hardening By (Name)			Ravi						
5	Material Sent For Hardening By (Name)			Lark Ramnare						
6	Material Sent For Hardening On Date			22	5	25				

Inspected By (Sign) & Date

22/5/25

Reviewed by (Engineer-CNC)

Manager-QA