



Lark Engineering Company (India) Pvt. Ltd.

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

10355

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		15464 ✓	57166
3	Pallet Die No.		V.T.L. H/c Shop	Drg. No. 130.330
4	Die Category	Drg. No.	15342 (8.0) H/c	Rev 208
5	Out Side Diameter	Drg. No.	H. Joriba	
6	Inside Diameter	Drg. No.	380.7 H/c	Step 00.69 2.8 H/c, Tappers 8°
7	Width of Pellet Die	Drg. No.	546.14 H/c (Box 548.2) H/c	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut = 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 + 9.1 H/c 32.7 + 9.1 H/c (4+8) H/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2 H/c Back
12	Tapping PCD		H/c Shop	Both Side
13	Tapping Hole Diameter		619 H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H/c : Check by H/c Bolt	of Holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth = 33.7 H/c	Tapping Depth = 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi: 24/7/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok	
			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	9.0 H/c	All Rows	Row = 10
3	External Relief Depth		9 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For race	
6	Material Sent For Hardening On Date		24 7 25	
Inspected By (Sign) & Date			Ravi: 24/7/25	

Reviewed by (Engineer-CNC)

Manager-QA