



Lark Engineering Company (India) Pvt. Ltd.

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

10433

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.		15651	55/60
2	Machined By		V. T. L. n/c Shop	Day No. 120-1362
3	Pallet Die No.		15347(4.0) n/c	Rev. no.
4	Die Category	Drg. No.	JG 10	
5	Out Side Diameter	Drg. No.	749.9 n/c Step 0.02	743.9 n/c Tapper 10
6	Inside Diameter	Drg. No.	630.14 n/c	Step length 0.3
7	Width of Pellet Die	Drg. No.	290.7 n/c	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 n/c / 15.3 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	0.8 n/c Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		685 n/c	Tapping H
13	Tapping Hole Diameter		H20. Crack by H20 Bolt	d Hole = 16
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth. 20.5 n/c	Tapping Depth 8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/8/25	
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 - 1 Hole Close only	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter = Go
2	External Relief Dia	4.5 n/c	Outside 23-33	Row = 43
3	External Relief Depth	13 n/c	Inner 5 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 8 25	
Inspected By (Sign) & Date			Ravi 7/8/25	

Reviewed by (Engineer-CNC)

Manager-QA