

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.		15575	75/75
2	Machined By		V. T. L. H/O Shop	Dr. No. 12.2 691
3	Pallet Die No.		16452 (8.0) H/O	Rev. 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1060.9 H/O Step 02. 1040.9 H/O Taper 4"	
6	Inside Diameter	Drg. No.	911.14 H/O / 911.8 H/O (Bore 911.9) Step length 29 H/O	
7	Width of Pellet Die	Drg. No.	388 H/O	
8	Grooves as per Drawing	Drg. No.	33x10x10 H/O / 33x10x9.6 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	1.44 Deep Both Side
11	Tapping Operator		H/O Shop	Tapping H/O
12	Tapping PCD		97.5 H/O	of Hole - 16 Both Side
13	Tapping Hole Diameter		42.40 Check by 42.4 Both	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 40.4 H/O Tapping Depth 45	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 14/10/25	
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 60 Ravi 30
2	External Relief Dia	9.0 H/O	Outside 3-3	Inner
3	External Relief Depth		8 H/O	Mill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravi	
6	Material Sent For Hardening On Date		14 10 25	
Inspected By (Sign) & Date			Ravi 14/10/25	

10872

Satya 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA