



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.		13806	40/50
2	Machined By		V.T.L. n/c Shop	Drg. No. U.O. 412
3	Pallet Die No.		12413 (4.0) n/c	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c, Step 00. 693 n/c	Step length. 12.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	14x8x7 n/c 14x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes. 12 Back Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20. Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 n/c	Tapping Depth. 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 9/1/25	Rinal Pitting
1	As per programme no.		---	Size Drg.
2	Gun Drilling Work Completed On		---	No. 1 e.o. 413
3	Hole Finish In Gun Drilling	Marked	ok	Pass 00
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				Counter Bo
1	Counter Sinking Depth & Finish	ok		Pass 32
2	External Relief Dia	4.5 n/c	outside (3-3)	Inner
3	External Relief Depth		12 n/c	Brn
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forance	
6	Material Sent For Hardening On Date		9 1 25	
Inspected By (Sign) & Date			Ravi 9/1/25	

Reviewed by (Engineer-CNC)

Manager-QA