



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.		13798	40/40
2	Machined By		V.T.C n/c Shop	Drg No. Lark 817
3	Pallet Die No.		13193 (4.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 n/c, Step OD = 395 n/c	Step length = 14.5
6	Inside Diameter	Drg. No.	390.12 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c / 15.5 x 7 x 2 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 8 Both Side
12	Tapping PCD		355 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.2 n/c	Tapping Depth = 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 8/1/25	
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
2	External Relief Dia	4.3 n/c	outside (2-2)	
3	External Relief Depth	4 n/c	Inner Mill	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8 / 1 / 25	
Inspected By (Sign) & Date			Ravi 8/1/25	

Reviewed by (Engineer-CNC)

Manager-QA