



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)

8940

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13817	45/45
2	Machined By		V. T. L. M/C Shop	Dy No. 130-541
3	Pallet Die No.		14083 (3.0) M/C	Rev. No.
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	409.9 M/C	Step 00 = 395 M/C
6	Inside Diameter	Drg. No.	320.12 M/C	Step length = 14.5
7	Width of Pellet Die	Drg. No.	142 M/C	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 M/C	15.5 x 7 x 2 M/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of holes = 2 Both Side
12	Tapping PCD		355 M/C	
13	Tapping Hole Diameter		M16 - Check by M16 B-11	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.2 M/C	Tapping Depth = 18.6 M/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

Counter = 6

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 M/C	outside 72.2		Inner				
3	External Relief Depth		8 M/C		Nil				
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