



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.		13860	40/50
2	Machined By		V.T.L H/c Shop	Drg No. 13.20.403
3	Pallet Die No.		14247 (4.0) H/H	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.5 H/H Step OD. 491 H/H	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No of Holes: 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		0.34" - Check by 0.34" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H/H Tapping Depth 16.6 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/1/25

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 60
Ravide

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/H	Outside (2-2)		Inner		
3	External Relief Depth		14 H/H		10 H/H		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		24	1	25		

Inspected By (Sign) & Date

Ravi 24/1/25

Reviewed by (Engineer-CNC)

Manager-QA