



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

9077

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13933	45/50
2	Machined By		V. T. L n/c Shop	Dy No. 1-20.1.969
3	Pallet Die No.		13844 (4.0) n/c	Revised
4	Die Category	Drg. No.	7ambo	
5	Out Side Diameter	Drg. No.	760 n/c, Step 00, 792 n/c	Step length 7.2 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Under Gun = 16 n/c
7	Width of Pellet Die	Drg. No.	324 n/c	
8	Grooves as per Drawing	Drg. No.	21x8x10 n/c 21x8x10 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 2-12 Both Side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 27.3 n/c	Tapping Depth 25.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/11/25	2 St. L
1	As per programme no.		_____	32.1 n/c width 9 n/c Depth Both Side
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, G- Law 2 48
2	External Relief Dia	4.5 n/c	outside (3-3)	Inner
3	External Relief Depth		13 n/c	5 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25	25
Inspected By (Sign) & Date			Ravi 25/11/25	

Reviewed by (Engineer-CNC)
 Sats 25/11/25

Manager-QA