



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.		13947	50/50
2	Machined By		V.T.L. n/c Shop	Dy. Insp. 18
3	Pallet Die No.		13184 (5.0) n/c	Revised
4	Die Category	Drg. No.	5910	(A)
5	Out Side Diameter	Drg. No.	519.7 n/c Step OD = 490.7 n/c	
6	Inside Diameter	Drg. No.	420.12 n/c	Step length = 7.5
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping of Holes 8 Both Side
12	Tapping PCD		454 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 = 18.3 n/c Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 25/1/25

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	5.3 n/c	outside (2-2)	Inner			
3	External Relief Depth		4 n/c	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		25	1	25		
Inspected By (Sign) & Date		Ravi 25/1/25					

Satish 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA