



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.			
2	Machined By		14171 ✓	32/55 ✓
3	Pallet Die No.		V.T.L. MLC Shop	Drig No. 1-3-D-0866
4	Die Category	Drg. No.	14104 (6.0) ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	Flt. H. Step 002 693 ✓	Tapper 12°
7	Width of Pellet Die	Drg. No.	600.12 ✓	Step length 2.2 ✓
8	Grooves as per Drawing	Drg. No.	2.2.2 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x18x7.5 ✓ / 12x10x7.5 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		MLC Shop	Tapping No of Holes - 12 Roth Side
13	Tapping Hole Diameter		640 ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20: Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 ✓	Tapping Depth 18.6 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Soni 13/2/25

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	6.5 ✓	Outside (3.3)		Inner			Rev. 22
3	External Relief Depth		29 ✓		23 ✓			
4	Inspection Done Before Hardening By (Name)							Soni
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		13	2	25			

Inspected By (Sign) & Date

Soni 13/2/25

Reviewed by (Engineer-CNC)

Manager-QA