



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14136 ✓	53155 ✓
2	Machined By		V.T.L. n/c Shop	Dy. No. 1202880
3	Pallet Die No.		14092 (3.8) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	529.944 ✓ Step OD: 491 ✓	Step length: 124 ✓
6	Inside Diameter	Drg. No.	420.12 ✓	
7	Width of Pellet Die	Drg. No.	182 ✓	
8	Grooves as per Drawing	Drg. No.	10x10x4.8 ✓ 10x10x4.9 ✓	
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: 8 Both Side
12	Tapping PCD		455 ✓	
13	Tapping Hole Diameter		Ø3/4" ✓ Check by Ø3/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.3 ✓	Tapping Depth = 17.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rawi 15/2/25

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° Rawi 28
2	External Relief Dia	4.3 ✓	Outside (2.2)		Inner		
3	External Relief Depth		9 ✓		2 ✓		
4	Inspection Done Before Hardening By (Name)						Rawi
5	Material Sent For Hardening By (Name)						Lark Forncel
6	Material Sent For Hardening On Date		15	2	25		

Inspected By (Sign) & Date

Rawi 15/2/25

Reviewed by (Engineer-CNC)

Manager-QA