



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		14246/	38/45/
3	Pallet Die No.		V.T.L. NLC Shop	Drg. No. L.E.G. 1543-
4	Die Category	Drg. No.	14062 (3.5) H4	Row 200
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	610 H4, Step 00: 612 H4	Step Length 20 H4
7	Width of Pellet Die	Drg. No.	520.12 H4	Undercut = 1 H4
8	Grooves as per Drawing	Drg. No.	222 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H4 13x3x5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		NLC Shop	
12	Tapping PCD		565 H4	Tapping dia of holes - 12 Bolt side
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H4	Tapping Depth 18.6 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 19/2/25

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						Count etc 60
2	External Relief Dia	U.0 H4	Outside (3-3)	Inner				Row 235
3	External Relief Depth		18 H4	7 H4				
4	Inspection Done Before Hardening By (Name)							Rasi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	2	25			

Inspected By (Sign) & Date

Rasi 19/2/25

Reviewed by (Engineer-CNC)
Sats 19/2/25

Manager-QA