



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.		14192 ✓	33/50
2	Machined By		V. T. L. H/C Shop	Dy. No. 13.9.450
3	Pallet Die No.		13492 (3.0) H/C	Rec: 00
4	Die Category	Drg. No.	742	
5	Out Side Diameter	Drg. No.	730 H/C	
6	Inside Diameter	Drg. No.	Step 00, 743.5 H/C	Tabber 10
7	Width of Pellet Die	Drg. No.	630.12 H/C	Step length 23 H/C
8	Grooves as per Drawing	Drg. No.	290 H/C	Undercut 6.75 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5 H/C 15x8x5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	Tapping No. of Holes 16 Both Side
13	Tapping Hole Diameter		885 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H/A Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 H/C	Tapping Depth 18.5 H/C
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 25/2/25

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 - 1 Hole Closed

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	3.5 H/C	Outside (3-3)		Inner		Raw 52
3	External Relief Depth		23 H/C		17 H/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	2	25		

Inspected By (Sign) & Date

Ravi 25/2/25

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

Manager-QA