



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)

9270

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14200 ✓	33/50 ✓
3	Pallet Die No.		V.T.L. N/C Shop	Drilling 13.0 = 450
4	Die Category	Dr. No.	13493(3.0) H ✓	Rev 200 ✓
5	Out Side Diameter	Dr. No.	780	
6	Inside Diameter	Dr. No.	730 H ✓ Step OD: 743.4 H ✓	Tapper 10°
7	Width of Pellet Die	Dr. No.	630.12 H ✓	Step length 83 H ✓
8	Grooves as per Drawing	Dr. No.	290 H ✓	Under cut 6.75
9	Fitting Sizes on CNC Plate	Dr. No.	15x8x5 H ✓ 15x8x5 H ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No of holes 16 Both Side
13	Tapping Hole Diameter		685 H ✓	
14	Tapping On Second Side	Half pitch of 1st side	M202 Check by M20 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Reamer 20.3 H ✓	Tapping Depth 18.6 H ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 24/2/25

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						Counters 60°
2	External Relief Dia	3.5 H ✓	Outside (3-3)		Inner			Rev 252
3	External Relief Depth		23 H ✓		17 H ✓			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		24	2	25			

Inspected By (Sign) & Date

Ravi 24/2/25

Satsa 24/2/25

Reviewed by (Engineer-CNC)

Manager-QA