



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.		14357 ✓	45/50
2	Machined By		V.T.L. H/C Shop	Drg No. 1-8-09980
3	Pallet Die No.		14170(5.0) H/C ✓	Rev. 100 ✓
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	619.9 H/C, Step 00, Tapper 12°	
6	Inside Diameter	Drg. No.	520.1 H/C	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 H/C ✓	
13	Tapping Hole Diameter		H2e2 Check by H2e Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/C Tapping Depth 18.5 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 6/3/25	
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 - Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter Go Ravi 28
2	External Relief Dia	5.5 H/C	outside (3-3)	Inner
3	External Relief Depth		10 H/C	5 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		6 3 25	
Inspected By (Sign) & Date			Ravi 6/3/25	

Sets 6/3/25

Reviewed by (Engineer-CNC)

Manager-QA