



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.		14353	38/45
2	Machined By		V.T.L. H/C Shop	Drg No. 12.0.202
3	Pallet Die No.		14380 (6.0) H/C	Rev. 00
4	Die Category	Drg. No.	542	
5	Out Side Diameter	Drg. No.	510 H/C Step 00, 491 H/C	Step length: 165
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	173 H/C	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/C 10x8.5x5 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: 8 Both Side
12	Tapping PCD		455 H/C	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.2 H/C	Tapping Depth 186
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/3/25

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter: 6
2	External Relief Dia	6.5 H/C	Outside (2+2)		Inner			Rev: 17
3	External Relief Depth		15 H/C		9 H/C			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		13	3	25			

Inspected By (Sign) & Date

Ravi 13/3/25

Reviewed by (Engineer-CNC)

Manager-QA