



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

9572

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14557	50/50
2	Machined By		V. T. L. H/c Shop	Qty 100 (100) 8088
3	Pallet Die No.		14825 (8.0) H/c	Reamed
4	Die Category	Drg. No.	10.2 Jumper	
5	Out Side Diameter	Drg. No.	419.8 H/c, Step 00.3948 H/c, Steplength 14.1	
6	Inside Diameter	Drg. No.	320.12 H/c	
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c 15.5 x 7 x 2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of holes - B Both Side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		H162 Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 10/4/25	
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 Bore Rao: 9
2	External Relief Dia	8.5 H/c	Outside 20.25	Inner
3	External Relief Depth		4 H/c	Will
4	Inspection Done Before Hardening By (Name)		Rao:	
5	Material Sent For Hardening By (Name)		Lark Purvare	
6	Material Sent For Hardening On Date		10 4 25	
Inspected By (Sign) & Date			Rao: 10/4/25	

Reviewed by (Engineer-CNC)

Manager-QA