



Lark Engineering Company (India) Pvt. Ltd.

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

9593

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.			
2	Machined By		14644	38/50
3	Pallet Die No.		V.T.L. n/c Shop	Qty 100
4	Die Category	Drg. No.	14484 (3.0) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	620 n/c Step 002 Tappet 12"	
7	Width of Pellet Die	Drg. No.	520.12 n/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		H20 = Clock by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Savi 11/4/25	
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 - Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 38
2	External Relief Dia	3.5 n/c	Outside (3.3)	Inner
3	External Relief Depth		18 n/c	12 n/c
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11 4 05	
Inspected By (Sign) & Date			Savi 11/4/25	

Reviewed by (Engineer-CNC)

Manager-QA