



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)

9726

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14697	Relu-419
3	Pallet Die No.		V.T.L H/c Shop	Dry H/c Lark 930
4	Die Category	Drg. No.	13509 (3.0) H/c	
5	Out Side Diameter	Drg. No.	Tenitor	
6	Inside Diameter	Drg. No.	400 H/c Step 00.395 H/c	Step length 14.5
7	Width of Pellet Die	Drg. No.	320.12 H/c	
8	Grooves as per Drawing	Drg. No.	142 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 H/c / 15.5 x 7 x 2 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping H/c
13	Tapping Hole Diameter		355 H/c	of H/c - B
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 H/c	Tapping Depth 18.0 H/c
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Relu 28/4/25

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 B
2	External Relief Dia	3.3 H/c	20.18 H/c	2-23		Inner		Row 2
3	External Relief Depth		10 H/c			4 H/c		
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		26	4	25			

Inspected By (Sign) & Date

Relu 28/4/25

Reviewed by (Engineer-CNC)

Manager-QA