



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)

9763

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14041	3215
2	Machined By		V.T.C. n/c Shop	Dr. 13.0.1394
3	Pallet Die No.		13135(40) n/c	Rev. 00
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	620 n/c Step 00. 612 n/c	Step length 13.5 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	166 n/c	
8	Grooves as per Drawing	Drg. No.	8x5x3 n/c / 8x5x8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 x Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 17.4 n/c	Tapping Depth 15.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/5/25	
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		
2	External Relief Dia	4.5 n/c	Outside 23-35	Inner 18 n/c
3	External Relief Depth		22 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Romare	
6	Material Sent For Hardening On Date		2 5 25	
Inspected By (Sign) & Date			Ravi 21/5/25	

8032
21/5/25

Reviewed by (Engineer-CNC)

Manager-QA