



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)

9814

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14788	30/51
2	Machined By		V. T. C. W/C Shop	Dr. H. 12.2.119
3	Pallet Die No.		14570 (3.0) 44	Rev. 44
4	Die Category	Drg. No.	Turns	
5	Out Side Diameter	Drg. No.	802 44 Step 00 802.5 44	Tapper. 40
6	Inside Diameter	Drg. No.	700.12 44	Step length 33 44
7	Width of Pellet Die	Drg. No.	324 44	Under cut = 10 34
8	Grooves as per Drawing	Drg. No.	30 x 8 x 8.5 44 30 x 8 x 8.5 44	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		W/C Shop	Tapping 44
12	Tapping PCD		760 44	of Holes 12
13	Tapping Hole Diameter		H22 Check by H22 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 36.4 44	Tapping Depth 34.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/5/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		OK	Counter 60
2	External Relief Dia		3.5 44	Row 1 53
3	External Relief Depth		24 44	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Rumar	
6	Material Sent For Hardening On Date		8 5 25	
Inspected By (Sign) & Date			Ravi 8/5/25	

Reviewed by (Engineer-CNC)

Manager-QA