



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)

9845

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14879	45/50
2	Machined By		V. T. L. H/c Shop	Qty 40, 1.2.2-406
3	Pallet Die No.		13851 (3.2) H/c	Rev = 00
4	Die Category	Drg. No.	Embroidide	
5	Out Side Diameter	Drg. No.	620 H/c Step 00- 624 H/c	Tappere 12°
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut 2 H/c
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Tapping H/c of holes 12 Both Side
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 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/5/25

1	As per programme no.		
2	Gun Drilling Work Completed On		yes
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No - 4 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok						Rev = 37
2	External Relief Dia	3.8 H/c	Outside (3.3)		Inner			
3	External Relief Depth		12 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		10	5	25			

Inspected By (Sign) & Date

Ravi 10/5/25

Reviewed by (Engineer-CNC)

Manager-QA