



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)

9843

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14869	40/45
2	Machined By		V. T. L. H/c. Shop	Dry H., 13.02.11
3	Pallet Die No.		12525(3.0) H/c	Rev: 00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	610 H/c, Step on 612 H/c	Step length 19.5 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Under cut 1 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/c	13 x 8 x 5 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		H20. Circle by H20 Ball	
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			Raw: 10/5/25	
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 - 3 Holes 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 H/c	Outside (3-3)	Inner
3	External Relief Depth		1 H/c	5 H/c
4	Inspection Done Before Hardening By (Name)		Raw!	
5	Material Sent For Hardening By (Name)		Lark Purvare	
6	Material Sent For Hardening On Date		10	5 25
Inspected By (Sign) & Date			Raw: 10/5/25	

Reviewed by (Engineer-CNC)

Manager-QA