



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14868	28/4/13
2	Machined By		V. T. L. n/c Shop	Drg. No. 13.0.639
3	Pallet Die No.		14045 (5.0) n/c	Rev. no
4	Die Category	Drg. No.	Ext. inside	
5	Out Side Diameter	Drg. No.	626 n/c Step on 624 n/c	Tapper 12
6	Inside Diameter	Drg. No.	52.14 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 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	[Tapping No. of holes = 12 Both Side]
13	Tapping Hole Diameter		M20.2 Reback by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.5 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Res: 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

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

Counter 60

1	Counter Sinking Depth & Finish	ok							Row 26
2	External Relief Dia	5.5 n/c / 6.0 n/c	5.5 n/c	All Rows 2 & 25 n/c					
3	External Relief Depth		6.0 n/c	All Rows 2 & 13 n/c					
4	Inspection Done Before Hardening By (Name)			Res:					
5	Material Sent For Hardening By (Name)			Lark Purane					
6	Material Sent For Hardening On Date		10	5	25				

Inspected By (Sign) & Date

Res: 10/5/25

Reviewed by (Engineer-CNC)

Manager-QA