



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9923

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.			
2	Machined By		14721	32/32
3	Pallet Die No.		V-7.1. n/c Shop	Dry No. 120.1297
4	Die Category	Drg. No.	14372(1.2) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	594 n/c, Step on 688 n/c	Step length 12.5
7	Width of Pellet Die	Drg. No.	530.14 n/c	
8	Grooves as per Drawing	Drg. No.	278 n/c	Load cut 44 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	43x8x8 n/c 22x8x8 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		594 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c Check by H20 Bolt	
15	Tapping Hole Depth		One Side Tapping and Two Side One	
16	Perpendicularity of Tapped Hole		Drill Depth: 25.4 n/c	Tapping Depth: 23.1
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 22/5/25

181.4

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)	10 Holes	no - 10 Holes Calused	

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

1	Counter Sinking Depth & Finish	OK 20% Match							
2	External Relief Dia								
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)	APPROVED By							
5	Material Sent For Hardening By (Name)	Satish Sir							
6	Material Sent For Hardening On Date		22	5	25				

Inspected By (Sign) & Date

Ravi 22/5/25

181.4

Satish Sir 22/5/25

Reviewed by (Engineer-CNC)

Manager-QA