



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)

9916

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14999	55/55
2	Machined By		V. T. L. w/c Shop	Dr. J. S. Ali 89
3	Pallet Die No.		14094(4.5) w/c	Rev.
4	Die Category	Drg. No.	SS 12	
5	Out Side Diameter	Drg. No.	530 w/c Step on 498.88	Tapper 12
6	Inside Diameter	Drg. No.	420.14 w/c	Step length 18
7	Width of Pellet Die	Drg. No.	182 w/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 w/c 12 x 8 x 3 w/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	Tapping H. of H. 8
12	Tapping PCD		454 w/c	Back Side
13	Tapping Hole Diameter		H20 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.8 w/c	Tapping Depth 18
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 21/5/25

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 B.

1	Counter Sinking Depth & Finish	ok						Raw: 22
2	External Relief Dia	5.0 w/c	Outside (2.25)		Inner			
3	External Relief Depth		4 w/c		Nil			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Raw: 21/5/25

Reviewed by (Engineer-CNC)

Manager-QA