



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)

9934

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14928	23/43/70
2	Machined By		V. T. L. w/o Shop	1 Drg. No. 18.2 382
3	Pallet Die No.		12995 (G.O) w/o	Rev. m
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	66.0 mm Step 0.02 622.9 mm	Tapping 12
6	Inside Diameter	Drg. No.	52.0 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	10 x 10 x 7 mm / 10 x 10 x 7 mm	Face Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	1 mm Deep
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		w/o Shop	Tapping 12
12	Tapping PCD		56.5 mm	of holes 12
13	Tapping Hole Diameter		M20. Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/5/25	2 Side
1	As per programme no.			25.1 mm hole dia
2	Gun Drilling Work Completed On			6 mm Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Row 219
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows 37	
3	External Relief Depth		7.0 mm All Rows 23 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permacore	
6	Material Sent For Hardening On Date		23 5 25	
Inspected By (Sign) & Date			Ravi 23/5/25	

23/5/25

Reviewed by (Engineer-CNC)

Manager-QA