



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.		14951	33/50
2	Machined By		V.T.L. H/c Shop	Dr. No. 1-2-3-4
3	Pallet Die No.		14602 (B-0) H/c	Rev. 01
4	Die Category	Drg. No.	MJF 10	
5	Out Side Diameter	Drg. No.	700 H/c Shop 002-892 H/c	Step length 19.8
6	Inside Diameter	Drg. No.	200.14 H/c	
7	Width of Pellet Die	Drg. No.	265.6 H/c	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 H/c / 15.3 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	0.8 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		340 H/c	Tapping H-9
13	Tapping Hole Diameter		H20, Check by H20 Bolt	2-16 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.7 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/5/25

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

1	Counter Sinking Depth & Finish	ok						Counter 20
2	External Relief Dia	3.5 H/c	Outside (3-3)		Inner			Row 2 47
3	External Relief Depth		23 H/c		17 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		28	5	25			

Inspected By (Sign) & Date

Ravi 28/5/25

Satya 26/5/25.
Reviewed by (Engineer-CNC)

Manager-QA