



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.		15033	34/40
2	Machined By		V. T. L. n/c Shop	Dy. 11.12.2013
3	Pallet Die No.		13766 (3.2) n/c	Rev. 01
4	Die Category	Drg. No.	58 n/c	
5	Out Side Diameter	Drg. No.	500 n/c, Step 00. 490.9 n/c	Step length 18.5
6	Inside Diameter	Drg. No.	420.14 n/c	
7	Width of Pellet Die	Drg. No.	173 n/c	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 n/c 10 x 8.5 x 5 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		455 n/c	
13	Tapping Hole Diameter		0.315" 2 Crack by 0.0315" Ball	
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
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/5/25

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	28 n/c	20 side (2.2)		Inner				
3	External Relief Depth		10 n/c		6 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purrace				
6	Material Sent For Hardening On Date		22	5	25				

Inspected By (Sign) & Date

Ravi 22/5/25

7/5/25

Reviewed by (Engineer-CNC)

Manager-QA