



Lark Engineering Company (India) Pvt. Ltd.

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

9963

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.		14924	55/66
2	Machined By		V.T.C. W/C Shop	Dry H. 12.0 = 39
3	Pallet Die No.		15148 (8.0) H	Rev. 08
4	Die Category	Drg. No.	M. Tumb	
5	Out Side Diameter	Drg. No.	380.1 H	Step 00. 693 H
6	Inside Diameter	Drg. No.	546.14 H	(Bot. 548.2 H) Step length = 31
7	Width of Pellet Die	Drg. No.	195 H	120 mm - 2.8
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H	(448) H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H Deep
11	Tapping Operator		W/C Shop	Both Side
12	Tapping PCD		619 H	Tapping H
13	Tapping Hole Diameter		H16. Check by H16 G.H	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.6 H	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 27/5/25	
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		Count on Bo
2	External Relief Dia	9.0 H	All Rows	Row 2 10
3	External Relief Depth		11 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permare	
6	Material Sent For Hardening On Date		27 5 25	
Inspected By (Sign) & Date			Ravi 27/5/25	

Reviewed by (Engineer-CNC)

Manager-QA