



Lark Engineering Company (India) Pvt. Ltd.

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

9984

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.		15103	44/46
2	Machined By		V. T. L. H/C Shop	Dry No. 1.26.2082
3	Pallet Die No.		13248 (4.0) H/C	Ren. 01
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	612 H/C	Step 00. G23 3 H/C
6	Inside Diameter	Drg. No.	520.12 H/C	Step length. 18.7
7	Width of Pellet Die	Drg. No.	186 H/C	Order cut = 5.7
8	Grooves as per Drawing	Drg. No.	1448x5 H/C / 1448x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping H. of holes - 12
13	Tapping Hole Diameter		M20x Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.6 H/C	Tapping Depth = 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 29/5/25	
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 60
2	External Relief Dia	4.5 H/C	Outside 2.3-3	Row 25
3	External Relief Depth		10 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29 5 25	
Inspected By (Sign) & Date			Ravi 29/5/25	

29/5/25

Reviewed by (Engineer-CNC)

Manager-QA