



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)

10016

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		1502Q	36/50
2	Machined By		V.T.L. H/c	Step
3	Pallet Die No.		13768 (3.0) H/c	18.02/351
4	Die Category	Drg. No.	5910	2000
5	Out Side Diameter	Drg. No.	520 H/c	Step 00. 498.88
6	Inside Diameter	Drg. No.	420.12 H/c	Tabben 212
7	Width of Pellet Die	Drg. No.	182 H/c	Step length 18 H/c
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c	Step
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20.1	Black by H20 Bolt
14	Tapping On Second Side	Half pitch of 1st side	ok	Tabbing No. of holes, 8
15	Tapping Hole Depth		Drill Depth, 18.4 H/c	Both Side
16	Perpendicularity of Tapped Hole		yes	Tabbing Depth, 16.5 H/c
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/6/25

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 - 4 Holes Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	13.5 H/c	20 H/c	22.25	Inner				
3	External Relief Depth		20 H/c		14 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 3/6/25

Reviewed by (Engineer-CNC)

Manager-QA