



Lark Engineering Company (India) Pvt. Ltd.

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

10014

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.			
2	Machined By		15047 ✓	32/55 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Drill H. 1.2.0.360
4	Die Category	Drg. No.	14272 (6.0) H/C	Rev 200
5	Out Side Diameter	Drg. No.	H. 100.60	
6	Inside Diameter	Drg. No.	709.9 H/C, Step 00. 693 H/C	Tappet. 12
7	Width of Pellet Die	Drg. No.	600.14 H/C	Step length 2.80 H/C
8	Grooves as per Drawing	Drg. No.	222 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12.1047.5 H/C / 12.1047.5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	Tapping H. of Holes. 12
13	Tapping Hole Diameter		H203 Check by H2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 H/C	Tapping Depth. 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/6/25

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

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

Counters 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H/C	Outside 23-3		Inner				
3	External Relief Depth		29 H/C		23 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 4/6/25

Satish 4/6/25

Reviewed by (Engineer-CNC)

Manager-QA