



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.		15208 ✓	36/42
2	Machined By		V.T.L. n/c Shop	Dy H. 13.0.928
3	Pallet Die No.		14851 (3.0) n/c	Renew
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	604 n/c, Step on 621.4 n/c	Tapping 12"
6	Inside Diameter	Drg. No.	520.14 n/c	Step length 21.5
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut 8.25
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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		565 n/c	Tapping H. of Holes - 12
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth - 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Row: 13/6/25

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	13.5 n/c	All Rows					Row 38
3	External Relief Depth		6 n/c					
4	Inspection Done Before Hardening By (Name)		Row					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	6	25			

Inspected By (Sign) & Date

Row: 13/6/25

Sato 13/6/25

Reviewed by (Engineer-CNC)

Manager-QA