



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)

10074

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14688	50/6-
2	Machined By		V.T.L. H/c Shop	Dr. H. (13.1.11-9)
3	Pallet Die No.		12371 (4.0) H/c	Revised
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	639.9 H/c, Step 00.311.8 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	52.14 H/c	
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 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	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
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 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

Counter Bore
Ravi 25

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/c	Outside (3-2)	Inner			
3	External Relief Depth		18 H/c	10 H/c			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		13	6	25		

Inspected By (Sign) & Date

Ravi 13/6/25

Reviewed by (Engineer-CNC)

Manager-QA