



Lark Engineering Company (India) Pvt. Ltd.

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

10086

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		15196	31/47
3	Pallet Die No.		V.T.L H/C Stop	Drg. No. 13021177
4	Die Category	Drg. No.	14608 (3.0) H/C	Rev. 00
5	Out Side Diameter	Drg. No.	H 750	
6	Inside Diameter	Drg. No.	694 H/C	Step 00. 702.6 H/C Tapping 12
7	Width of Pellet Die	Drg. No.	600.14 H/C	Step length 2
8	Grooves as per Drawing	Drg. No.	260 H/C	Under cut 4.3
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x6 H/C / 10x10x8 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Stop	Tapping H/C
13	Tapping Hole Diameter		645 H/C	of holes = 12
14	Tapping On Second Side	Half pitch of 1st side	H 202 Check by H 20 B.11	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth. 22.4 H/C	Tapping Depth 22.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev: 14/6/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		N.

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	3.5 H/C	Outside (3.3)		Inner			Rev: 47
3	External Relief Depth		19 H/C		16 H/C			
4	Inspection Done Before Hardening By (Name)							Rev:
5	Material Sent For Hardening By (Name)							Lark Panyore
6	Material Sent For Hardening On Date		14	6	25			

Inspected By (Sign) & Date

Rev: 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA