



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)

10141

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15189	45/00
2	Machined By		V.T.L. n/c Shop	Dry H. 1.32/34.5
3	Pallet Die No.		14753 (B.O) n/c	Rev 2.00
4	Die Category	Drg. No.	Turn 30	
5	Out Side Diameter	Drg. No.	780 n/c Shop 00.797.8 n/c Tapper 24	
6	Inside Diameter	Drg. No.	660.14 n/c	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 n/c	Load cut. 9 n/c
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 n/c / 21.5 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Holes. 12 Both Side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		H2. Check by H2 B.O.	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 23.4 n/c Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Savi 23/6/25	23.1.2
1	As per programme no.			32.1 n/c kind
2	Gun Drilling Work Completed On			8 n/c Depth
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
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 B.O. 23/6/25
2	External Relief Dia	8.5 n/c	23.25	inner
3	External Relief Depth		23 n/c	15 n/c
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Parrao	
6	Material Sent For Hardening On Date		23	25
Inspected By (Sign) & Date			Savi 23/6/25	

Reviewed by (Engineer-CNC)

Manager-QA