



Lark Engineering Company (India) Pvt. Ltd.

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

10213

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		15354	42/50
3	Pallet Die No.		V.7.1 n/c Shop	Dy. H. L. S. 1493
4	Die Category	Drg. No.	14420 (40) n/c	Rem 100
5	Out Side Diameter	Drg. No.	M. 100 n/c	
6	Inside Diameter	Drg. No.	700 n/c Shop 00. 693 n/c	Tapping 12
7	Width of Pellet Die	Drg. No.	800.14 n/c	Step length 20 n/c
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 n/c 12x10x7.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping 12
13	Tapping Hole Diameter		640 n/c	of holes 12
14	Tapping On Second Side	Half pitch of 1st side	1200 Check by 1200 Bolt	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18.0
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 4/7/25

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	4.5 n/c	20 Side 20-35		Inner					Rem 33
3	External Relief Depth		12 n/c		8 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Purnace
6	Material Sent For Hardening On Date			4	7	25				

Inspected By (Sign) & Date

Ravi 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA