



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)

10363

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14902	30/50
2	Machined By		V.T.L. H/C Shop	Qty No. 18.2
3	Pallet Die No.		15295(3.0) H/C	Renewal
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/C - Step 00. 615.4 H/C	Tapper 40
6	Inside Diameter	Drg. No.	520.14 H/C	Step length 20
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping No of holes = 12
13	Tapping Hole Diameter		H20 x Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/7/25	
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 - 6
2	External Relief Dia	3.3 H/C	20.3 H/C	Inner
3	External Relief Depth		23 H/C	20 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25	7
Inspected By (Sign) & Date			Ravi 25/7/25	

Reviewed by (Engineer-CNC)

Manager-QA