



Lark Engineering Company (India) Pvt. Ltd.

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

10425

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		15674	37/45
3	Pallet Die No.		N.T.L. H/c Shop	Dr. H. 12.0.807
4	Die Category	Drg. No.	15876(5.0) H/c	Rev. co
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	510 H/c Step 002 492 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	42.14 H/c	
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		454 H/c	
14	Tapping On Second Side	Half pitch of 1st side	03/4" 2 Check by 03/4" Bolt	Tapping H/c of Hole 8 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 H/c	Tapping Depth 18.7
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Pass: 5/8/25

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. Go
2	External Relief Dia	5.5 H/c	Outside (2-2)		Inner			Pass 17
3	External Relief Depth		13 H/c		8 H/c			
4	Inspection Done Before Hardening By (Name)							Pass
5	Material Sent For Hardening By (Name)							Lark Purrace
6	Material Sent For Hardening On Date			5	8	25		
								Pass: 5/8/25

Inspected By (Sign) & Date

Pass: 5/8/25

Reviewed by (Engineer-CNC)

Manager-QA