



Lark Engineering Company (India) Pvt. Ltd.

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

10416

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.		15619	33/45
2	Machined By		V. T. L. H/C Shop	Day No. 18.0.1147
3	Pallet Die No.		15852 (4.0) H/C	Rev 2.00
4	Die Category	Drg. No.	S960	
5	Out Side Diameter	Drg. No.	510 H/C	Step 0.02 499 H/C
6	Inside Diameter	Drg. No.	420.14 H/C	Tapping H/C
7	Width of Pellet Die	Drg. No.	182 H/C	Step length 1.20 H/C
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Tapping H/C of H.1222 B
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 18.5 H/C	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 4/8/25

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 60°
2	External Relief Dia	4.5 H/C	outside (2.25)		Inner			Row = 25
3	External Relief Depth	✓	17 H/C		12 H/C			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		4	8	25			

Inspected By (Sign) & Date

Raw: 4/8/25

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Reviewed by (Engineer-CNC)

Manager-QA