



Lark Engineering Company (India) Pvt. Ltd.

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

10414

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		15370	40/50
3	Pallet Die No.		V. T. L. H/C Shop	By H/C 15370
4	Die Category	Drg. No.	15973(4.0) H/C	Rev. 03
5	Out Side Diameter	Drg. No.	H/C	
6	Inside Diameter	Drg. No.	701 H/C Step 00.703 H/C Tapper. 12	
7	Width of Pellet Die	Drg. No.	600.14 H/C (Bore = 599.7 H/C)	Step length 17.4 H/C
8	Grooves as per Drawing	Drg. No.	265.6 H/C	Order cut 1 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	15.3 x 8 x 7 H/C / 15.3 x 8 x 7 H/C	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		OK	0.8 H/C Deep
12	Tapping PCD		H/C Shop	Both Side
13	Tapping Hole Diameter		640 H/C	Tapping H/C
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	of Holes 16
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 20.6 H/C	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		Yes	
			OK	
Inspected By (Sign) & Date			Ravi 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	80 Side 3-35	Inner
3	External Relief Depth		14 H/C	10 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		4 8 25	
Inspected By (Sign) & Date			Ravi 4/8/25	

Reviewed By (Engineer-CNC)

Manager-QA