



Lark Engineering Company (India) Pvt. Ltd.

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

9856

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		INV	36/40
3	Pallet Die No.		V.T.L H/c Shop	Dry No. 1.2.0.15.02
4	Die Category	Drg. No.	14686(4.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Sentax	
6	Inside Diameter	Drg. No.	5mm H/c Step 002 498.88	Tapping H/c 12
7	Width of Pellet Die	Drg. No.	420.12 H/c	Step Length 18 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		H/c Shop	
12	Tapping PCD		454 H/c	Tapping H/c of Holes 8
13	Tapping Hole Diameter		H/c Check by H/c Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H/c	Tapping Depth 16.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 13/5/25

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

Counter = 60

1	Counter Sinking Depth & Finish	OK						Raw: 13/5/25
2	External Relief Dia	4.3 H/c	Outside (2.2)		Inner			
3	External Relief Depth		8 H/c		4 H/c			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Purvace
6	Material Sent For Hardening On Date		13	5	25			

Inspected By (Sign) & Date

Raw: 13/5/25

Sat 13/5/25

Reviewed by (Engineer-CNC)

Manager-QA