

Lark Engineering Company (India) Pvt. Ltd.

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

10458

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 to 15725	40/40
3	Pallet Die No.		V.T.L. n/c Shop	Dy No. 15725-02
4	Die Category	Drg. No.	14895(4.0) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 n/c, 8 step 00. 498.88	Tabber 12"
7	Width of Pellet Die	Drg. No.	420.14 n/c	Step length 8 n/c
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c
13	Tapping Hole Diameter		454 n/c	of holes 8
14	Tapping On Second Side	Half pitch of 1st side	120 x Crack by 420 Bolt	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.7 n/c	Tapping Depth 16.7
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Savi 12/8/25	convert to
1	As per programme no.			Lark Std. in
2	Gun Drilling Work Completed On			final size
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 - 20
2	External Relief Dia	4.5 n/c	22.25	Inner
3	External Relief Depth	4 n/c	Nil	
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		12 8 25	
Inspected By (Sign) & Date			Savi 12/8/25	

Reviewed by (Engineer-CNC)

Manager-QA