



Lark Engineering Company (India) Pvt. Ltd.

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

10506

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		15713/	35/40
3	Pallet Die No.		V.7.L H/c Shop	Drg. No. L.F.O. 15-62
4	Die Category	Drg. No.	15274(3.2) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	500 H/c	Senior
6	Inside Diameter	Drg. No.	Step 00. 498.8	Tapper 13"
7	Width of Pellet Die	Drg. No.	420.14 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.	12+8+3 H/c	12+8+3 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	H202 Check by H20 B-12	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.6 H/c	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 21/8/25

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 63
2	External Relief Dia	3.5 H/c	20 Side			Inner				Rev. 22
3	External Relief Depth		17 H/c			5 H/c				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Ravi 21/8/25

Reviewed by (Engineer-CNC)

Manager-QA