



Lark Engineering Company (India) Pvt. Ltd.

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

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.		15867	33/40
2	Machined By		V. T. L. H/c Shop	By H. Lark
3	Pallet Die No.		15082(3.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 H/c Step 00. 490.9 H/c	
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		454 H/c	of H/c. B
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 18.9 H/c	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai 25/8/25	
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 6.0
2	External Relief Dia	3.5 H/c	Outside 2.25	Row 24
3	External Relief Depth		13 H/c	Inner 7 H/c
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25	25
Inspected By (Sign) & Date			Sai 25/8/25	

Reviewed by (Engineer-CNC)

Manager-QA