



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 (Pilot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15785	60/60
2	Machined By		V.T.L. H/c Shop	Dy. H/c J. S. 10/4/13
3	Pallet Die No.		16027 (5.0) H/c	Rev. 00
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	639.8 H/c	Step on G11.8 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 19.8
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		H20, Crack by H20 Bolt	Tapping H/c of holes 12 Bolt 2.0
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

26/8/25

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							
2	External Relief Dia	5.5 H/c	8.3-3	Outside	Inner				
3	External Relief Depth	5 H/c		Mill					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		02	8	25				

Inspected By (Sign) & Date

26/8/25

Reviewed by (Engineer-CNC)

Manager-QA