

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.		16154	410/50
2	Machined By		V. T. L. n/c. Shop	Dry Hole 12.2.4 19
3	Pallet Die No.		14583 (5.0) n	Recess
4	Die Category	Drg. No.	M. 7.0 n/c	
5	Out Side Diameter	Drg. No.	7.00 n/c Step 0.02	891.9 n/c
6	Inside Diameter	Drg. No.	6.00.14 n/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c	12.5 x 8 x 7 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	
12	Tapping PCD		645 n/c	
13	Tapping Hole Diameter		W20. Check by W20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.4 n/c	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 29/9/25	
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 n/c	23-35	Inner
3	External Relief Depth		15 n/c	10 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29 9 25	
Inspected By (Sign) & Date			Ravi 29/9/25	

Reviewed by (Engineer-CNC)

Manager-QA