

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)

10855

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16172	36/40
2	Machined By		V. T. L. H/c Shop	Drg. No. 15-62
3	Pallet Die No.		15669(4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step 02, 498.8	Tapping 12
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c 12 x 8 x 3 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 of Holes 8
12	Tapping PCD		454 H/c	Both Side
13	Tapping Hole Diameter		H/c Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/10/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK								Rev. 20
2	External Relief Dia	4.5 H/c	2-25		Inner					
3	External Relief Depth		8 H/c		4 H/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Resonance					
6	Material Sent For Hardening On Date		13	10	25					

Inspected By (Sign) & Date

Ravi 13/10/25

Satya 31/10/25

Reviewed by (Engineer-CNC)

Manager-QA