



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.		18400	33/47
2	Machined By		V. T. L. M/c Shop	Drg No. 18.0.996
3	Pallet Die No.		14954 (3.0) M/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	694 M/c	Step 00. 693 M/c
6	Inside Diameter	Drg. No.	600.14 M/c	Tabber. 4
7	Width of Pellet Die	Drg. No.	222 M/c	Step length. 80 M/c
8	Grooves as per Drawing	Drg. No.	14x8x7 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640 M/c	
13	Tapping Hole Diameter		M2.2 Check by M2.0 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 22.3 M/c	Tapping Depth. 20.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/25

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. 60
2	External Relief Dia	3.5 M/c	Outside 2.3-3.1		Inner					Rev. 38
3	External Relief Depth		20 M/c		14 M/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		01	11	25					

Inspected By (Sign) & Date

Ravi 11/1/25

Reviewed by (Engineer-CNC)

Manager-QA