



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)

9968

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15007	40/50
2	Machined By		V.T.L. H/c Shop	Dr. H. L. S. 299
3	Pallet Die No.		15120 (4.0) H/c	Ream
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 H/c	Step 002 50mm Tapping 100
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.	12-8-3 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		455 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai 28/5/25	
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 G. 2022
2	External Relief Dia	4.5 H/c	Outside 2.2	Inner
3	External Relief Depth		14 H/c	10 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		22	5 25
Inspected By (Sign) & Date			Sai 28/5/25	

Reviewed by (Engineer-CNC)

Manager-QA