



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10354

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.			
2	Machined By		15484	32/50
3	Pallet Die No.		V.T.L. H/c Shop	Drilling 18mm 9780
4	Die Category	Drg. No.	14840(3.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	9.4mm wide	
6	Inside Diameter	Drg. No.	619.8mm Step 00	Tapping 12
7	Width of Pellet Die	Drg. No.	520.14mm	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm 13x8x5mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565mm	
14	Tapping On Second Side	Half pitch of 1st side	142mm Check by H/c Bolt	Tapping H/c of holes 12 Bolt Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4mm	Tapping Depth 18
17	Visual Inspection Before Gun Drilling		yes	
			OK	
Inspected By (Sign) & Date			Ravi 24/7/25	
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	3.5mm	Outside 28-35	Inner
3	External Relief Depth		18mm	12mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		24	7 25
Inspected By (Sign) & Date			Ravi 24/7/25	

Reviewed by (Engineer-CNC)

Manager-QA