



Lark Engineering Company (India) Pvt. Ltd.

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

10662

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		16069	33/40
3	Pallet Die No.		N.T.C. H/c Shop	Dry Hole 1.8 C.I. 5-6
4	Die Category	Drg. No.	15097 (2.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.9 H/c	Step 00. 498.8 H/c
7	Width of Pellet Die	Drg. No.	420.14 H/c	Tappet, 12"
8	Grooves as per Drawing	Drg. No.	158 H/c	Step length 18"
9	Fitting Sizes on CNC Plate	Drg. No.	12-8-3 H/c / 12-8-3 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		452.9 H/c	Tapping H/c of Hole, 8
13	Tapping Hole Diameter		H20-2 Check by H20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.6 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/9/25

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						Counter 60
2	External Relief Dia	3.5 H/c	82-25	Inner				Ravi 24
3	External Relief Depth		13 H/c	7 H/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		18	9	25			

Inspected By (Sign) & Date

Ravi 18/9/25

Reviewed by (Engineer-CNC)

Manager-QA