



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.		13944	45/50
2	Machined By		V.T.L. n/c Shop	Drg. No. L.E. 0998
3	Pallet Die No.		13721 (3-5) n/c	Low on
4	Die Category	Drg. No.	Frontside	
5	Out Side Diameter	Drg. No.	619.8 n/c	Step on. Gapper. 12
6	Inside Diameter	Drg. No.	520.3 n/c	Step length. 18.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c / 13 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes. 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M2. Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.2 n/c	Tapping Depth. 18.5 n/c
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

Counter. 60° Low. 35

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0 n/c	outside (2-3)		Inner		
3	External Relief Depth		12 n/c		5 n/c		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark for work		
6	Material Sent For Hardening On Date		11	1	25		

Inspected By (Sign) & Date

Ravi 11/1/25

Sats 13/1/25

Reviewed by (Engineer-CNC)

Manager-QA