



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)

9/20

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14073 ✓	37/50, 355
2	Machined By		V. T. L H/c Shop	Dry H., Lenk 3310
3	Pallet Die No.		13833(5.0) ✓	
4	Die Category	Drg. No.	Ext. side	
5	Out Side Diameter	Drg. No.	619.9 H/c Step 00. 611.9 H/c	Step length 175
6	Inside Diameter	Drg. No.	520.12 H/c (Bore Tapper 0.2) H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes, 12 Both side
12	Tapping PCD		565 H/c ✓	
13	Tapping Hole Diameter		H2 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c Tapping Depth 18.6 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/1/25

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 Go
Ravi 26

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	5.5 H/c	Outside (3-3)	Inner		
3	External Relief Depth		18 H/c	13 H/c		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Romare			
6	Material Sent For Hardening On Date		31	1	25	

Inspected By (Sign) & Date

Ravi 31/1/25

31/1/25
Reviewed by (Engineer-CNC)

Manager-QA