



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.		13290	60/65
2	Machined By		V. T. L. H/c. Shop	Dry No. 18.09.51
3	Pallet Die No.		14424(4.5) H/c	Rev = 00
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	549.9 H/c, 3rd 00, 491 H/c	Step length 17.5
6	Inside Diameter	Dr. No.	420.12 H/c	
7	Width of Pellet Die	Dr. No.	158 H/c	
8	Grooves as per Drawing	Dr. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	[Tapping No. of holes = 8 Both Side]
12	Tapping PCD		454 H/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 18.3 H/c	Tapping Depth 16.0 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/7/25

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter = 60 Rev = 18
2	External Relief Dia	5.0 H/c	outside (2-2)		Inner			
3	External Relief Depth		14 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Rorance
6	Material Sent For Hardening On Date		18	2	25			

Inspected By (Sign) & Date

Ravi 18/7/25

Satyam 18/7/25

Reviewed by (Engineer-CNC)

Manager-QA