



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.		14457	30/50
2	Machined By		V. T. L. n/c Shop	Dy. No. 18.0-450
3	Pallet Die No.		13497 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	5410	
5	Out Side Diameter	Drg. No.	73.0 n/c	Step 002 743.4 n/c
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 23 n/c
7	Width of Pellet Die	Drg. No.	290 n/c	Under cut 6.8 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c	15x8x5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M20, Check by M20 B. It	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/3/25

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 20
2	External Relief Dia	3.3 n/c	Outside (3-3)			Inner				Rev 2 52
3	External Relief Depth		23 n/c			20 n/c				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		17	3	25					

Inspected By (Sign) & Date

Ravi 12/3/25

Reviewed by (Engineer-CNC)

Manager-QA