

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

9485

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14541	36/40
2	Machined By		V.T.L. H/c Shop	Dy. H. Lark
3	Pallet Die No.		14536 (3.0) H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 H, Step 002 490.9 H	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H 12x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		H 202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/25

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, B.
2	External Relief Dia	3.3 H	Outside 2-25		Inner					
3	External Relief Depth		10 H		4 H					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Ravi 31/7/25

Reviewed by (Engineer-CNC)

Manager-QA