



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.		14600	36/50
2	Machined By		V.T.L. n/c Shop	Dr. H. 1.8.02.30.2
3	Pallet Die No.		14720 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	H. 7mm 60	
5	Out Side Diameter	Drg. No.	680 n/c	Step 002 683.9 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 200 n/c
7	Width of Pellet Die	Drg. No.	182 n/c	Under cut 2 n/c
8	Grooves as per Drawing	Drg. No.	12x10x5 n/c / 12x10x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. of Hole 12
12	Tapping PCD		565 n/c	Bottom Side
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 8/4/25	
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 Go
2	External Relief Dia	4.5 n/c	Outside 2.3-3	Inner
3	External Relief Depth		18 n/c	14 n/c
4	Inspection Done Before Hardening By (Name)			
5	Material Sent For Hardening By (Name)		Lark Forname	
6	Material Sent For Hardening On Date		8 4 25	
Inspected By (Sign) & Date			Sasi 8/4/25	

Reviewed by (Engineer-CNC)

Manager-QA