



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.		14537	31/50
2	Machined By		V.T.L H/c Shop	Dry H. 18.0.25
3	Pallet Die No.		14402 (B.O) H/c	Rev 200
4	Die Category	Drg. No.	M. 7mm ho	
5	Out Side Diameter	Drg. No.	7mm H/c Step 002 69 H/c	Step length 19mm
6	Inside Diameter	Drg. No.	3mm. 14 H/c	
7	Width of Pellet Die	Drg. No.	220 H/c	
8	Grooves as per Drawing	Drg. No.	9.5x10x6 H/c / 9.5x10x6 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. of Holes 12
12	Tapping PCD		64.5 H/c	Both Side
13	Tapping Hole Diameter		H202 C. back by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.4 H/c	Tapping Depth 20.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 10/4/25	
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 26
2	External Relief Dia	3.5 H/c	20.5 H/c	Inner 19 H/c
3	External Relief Depth		22 H/c	
4	Inspection Done Before Hardening By (Name)		Rao:	
5	Material Sent For Hardening By (Name)		Lark Porre	
6	Material Sent For Hardening On Date		10 4 25	
Inspected By (Sign) & Date			Rao: 10/4/25	

Reviewed by (Engineer-CNC)

Manager-QA