



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.		14662	31/40
2	Machined By		V.T.L. H/c Shop	Drilling 12.02.865
3	Pallet Die No.		14949 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 H/c Step 02. 383 H/c	Step length 11.5 H/c
6	Inside Diameter	Drg. No.	310.12 H/c	
7	Width of Pellet Die	Drg. No.	135 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		350 H/c	
13	Tapping Hole Diameter		33/4" = Check by 33/4" Ball	Tapping No. of holes 8 Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/4/25

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

Count 21

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 H/c	outside (2.2)		Inner				
3	External Relief Depth		15 H/c		9 H/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porrace				
6	Material Sent For Hardening On Date		19	4	25				

Inspected By (Sign) & Date

Ravi 19/4/25

Reviewed by (Engineer-CNC)

Manager-QA