



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.		14697	36/40
2	Machined By		V. T. L. H/c Shop	Dr. H. Lark
3	Pallet Die No.		13508 (3.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/c	Step 00: 395 H/c
6	Inside Diameter	Drg. No.	320.12 H/c	Step length: 14.5
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c	15.5 x 7 x 2 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		355 H/c	
13	Tapping Hole Diameter		N/A	Check by N/A Bolt
14	Tapping On Second Side	Half pitch of 1st side	ok	Tapping of H/c: 8
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 18.8 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/4/25

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 Bo
2	External Relief Dia	3.3 H/c	2.2		Inner					
3	External Relief Depth		10 H/c		4 H/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Perance
6	Material Sent For Hardening On Date		24	4	25					

Inspected By (Sign) & Date

Ravi 24/4/25

Reviewed by (Engineer-CNC)

Manager-QA