



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.		14441	31/50
2	Machined By		V.T.L. H/c Shop	Dy H/c 1.2.2.9 980
3	Pallet Die No.		14301 (2.2) H/c	Revised
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	620 H/c	Step 002 Tapping 12
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		585 H/c	
13	Tapping Hole Diameter		H20	Tapping H/c of holes = 12
14	Tapping On Second Side	Half pitch of 1st side	Check by H20 Bolt	Both Side
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/5/25

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 60
2	External Relief Dia	3.5 H/c	Outside 23-35		Inner			Low 37
3	External Relief Depth		22 H/c		19 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ravnace
6	Material Sent For Hardening On Date		3	5	25			

Inspected By (Sign) & Date

Ravi 3/5/25

Reviewed by (Engineer-CNC)

Manager-QA