



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.		14856	40/40
2	Machined By		V.T.C. HLC Shop	Dr. No. (20.15) 62
3	Pallet Die No.		14684 (4.0) HLC	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HLC Step 00, 498.88	Tapper 12
6	Inside Diameter	Drg. No.	420.12 HLC	Step length 18
7	Width of Pellet Die	Drg. No.	158 HLC	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 HLC 12 x 8 x 3 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		HLC Shop	Tapping Ho of Hole 8
12	Tapping PCD		454 HLC	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 HLC Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Y08	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/5/25	
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	4.5 HLC	20 Side (2.25)	Inner
3	External Relief Depth		4 HLC	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permacore	
6	Material Sent For Hardening On Date		8 5 25	
Inspected By (Sign) & Date			Ravi 8/5/25	

Reviewed by (Engineer-CNC)

Manager-QA