



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

4914

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.		14935	40/4-219
2	Machined By		V. T. L. n/c Shop	Dy. M. Lark
3	Pallet Die No.		13762 (4.0) n/c	
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	500 n/c Step 02 490.9 n/c	Step length 17.
6	Inside Diameter	Drg. No.	42.12 n/c	
7	Width of Pellet Die	Drg. No.	181.7 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Ball	Tapping of Hole 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.6 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/5/25

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 n/c	Outside 22-23		Inner			Ravi 25
3	External Relief Depth		4 n/c		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Ramesh			
6	Material Sent For Hardening On Date		21	5	25			

Inspected By (Sign) & Date

Ravi 21/5/25

Reviewed by (Engineer-CNC)

Manager-QA