



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.		14951	28/5/25
2	Machined By		V. T. L. H/c Shop	By H. 18.2 244
3	Pallet Die No.		14599 (2.8) H/c	Rev. 201
4	Die Category	Drg. No.	H. 7410	
5	Out Side Diameter	Drg. No.	700 H/c Step no. 692 H/c	Step length 19.8
6	Inside Diameter	Drg. No.	600.14 H/c	
7	Width of Pellet Die	Drg. No.	285.6 H/c	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 H/c	15.3 x 8 x 7 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	0-8 H/c Deep
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		H/c Shop	Tapping H.
12	Tapping PCD		640 H/c	of holes. 16
13	Tapping Hole Diameter		H. 20.2 Check by H. 20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.8 H/c	Tapping Depth. 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 28/5/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter Sink 2.6
2	External Relief Dia	2.8 H/c	outside (2.8-3)	Inner
3	External Relief Depth		25 H/c	22 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permare	
6	Material Sent For Hardening On Date		28 5 25	
Inspected By (Sign) & Date			Ravi 28/5/25	

Reviewed by (Engineer-CNC)

Manager-QA