



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.		15050	42/50
2	Machined By		V. T. L. w/c Shop	Day 4. 12.0.450
3	Pallet Die No.		15223(4.0) NW	Revision
4	Die Category	Drg. No.	720	Rev 01
5	Out Side Diameter	Drg. No.	730 NW Step 00. 743.2 NW	Tabber 10
6	Inside Diameter	Drg. No.	630.12 NW	Step length. 23 NW
7	Width of Pellet Die	Drg. No.	290 NW	Under cut. 6.6 NW
8	Grooves as per Drawing	Drg. No.	15x8x5 NW 15x8x5 NW	Face side 0.5 NW
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Deep Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		w/c Shop	
12	Tapping PCD		68.5 NW	
13	Tapping Hole Diameter		H20 : Check by H20 Ball	Tapping 10 of Holes. 18
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth. 20.4 NW	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/6/25

1	As per programme no.									Face groove
2	Gun Drilling Work Completed On									Day 12.0.450
3	Hole Finish In Gun Drilling	Marked								Rev. 01
4	Defective Holes (If Any)									

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								Counter 2 B
2	External Relief Dia	4.5 NW	Outside (3-3)			Inner				
3	External Relief Depth		12 NW			8 NW				
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porriace
6	Material Sent For Hardening On Date									6 6 25

Inspected By (Sign) & Date

Ravi 6/6/25

Reviewed by (Engineer-CNC)

Manager-QA