



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.		15026	48/50
2	Machined By		V.T.L. H/c Shop	Dr. H. 12.0.13
3	Pallet Die No.		14969 (C.0) H/c	Rev. 00
4	Die Category	Drg. No.	3212	
5	Out Side Diameter	Drg. No.	520 H/c	Step 00-498.88 Tapper 12
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H2, Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8 H/c	Tapping Depth 18.9
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 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

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 H/c	Outside 22.2		Inner					Raw: 25
3	External Relief Depth		10 H/c		2 H/c					
4	Inspection Done Before Hardening By (Name)									Raw!
5	Material Sent For Hardening By (Name)									Lark Perma
6	Material Sent For Hardening On Date		22	5	25					

Inspected By (Sign) & Date

Raw: 28/5/25

Satyam
27/5/25

Reviewed by (Engineer-CNC)

Manager-QA