



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15044	50/6-
2	Machined By		V.T.L. n/a Shop	Drg. No. 1.5.2010
3	Pallet Die No.		14160(7.0)mm	Revised
4	Die Category	Drg. No.	M. Tumb	
5	Out Side Diameter	Drg. No.	7.0mm, Step 0.2 693mm	Tapping 12
6	Inside Diameter	Drg. No.	6.0mm 1.4mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	12x 8x 7mm / 12x 8x 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping 4
12	Tapping PCD		640mm	of holes 12
13	Tapping Hole Diameter		4mm 2 Check by H20 Bolt	Bolt side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai 7/6/25	
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	7.5mm	outside (3-3)	8mm 20
3	External Relief Depth		17mm	10mm
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark For more	
6	Material Sent For Hardening On Date		7 6 25	
Inspected By (Sign) & Date			Sai 7/6/25	

Reviewed by (Engineer-CNC)

Manager-QA