



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.		15150	3060
2	Machined By		V.T.L. H/c Shop	Dr. H. S. N. 16 478
3	Pallet Die No.		11778(5.0) H/c	Rev. 10
4	Die Category	Drg. No.	2x transverse	
5	Out Side Diameter	Drg. No.	640 H/c	Step 00.612 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 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		565 H/c	
13	Tapping Hole Diameter		H/c. Check by H/c Ball	Tapping H/c of holes 12 Botu Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 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 - 1 Hole Glued	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 60 Row 26
2	External Relief Dia	5.5 H/c	outside (3-3)	Inner
3	External Relief Depth		5 H/c	N:11
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 6 25	
Inspected By (Sign) & Date			Ravi 7/6/25	

Reviewed by (Engineer-CNC)

Manager-QA