



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10034

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.		15106 ✓	58/66 ✓
2	Machined By		V. T. L. n/c Shop	Dry Holes 12.0.200
3	Pallet Die No.		15216 (9.0) n/c	Row 2 08
4	Die Category	Drg. No.	N. Tumbo	
5	Out Side Diameter	Drg. No.	680.1 n/c	Step 00, 693 n/c
6	Inside Diameter	Drg. No.	546.12 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	(2000000 - 2.8 n/c)
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		n/c Shop	2 n/c Deep
12	Tapping PCD		619 n/c	Both Side
13	Tapping Hole Diameter		OK	Tapping Holes
14	Tapping On Second Side	Half pitch of 1st side	OK	of Holes 2
15	Tapping Hole Depth		Drill Depth 23.4 n/c	Tapping Depth 31.6 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 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	10.000	01	Row 5					Row 2 8
3	External Relief Depth			8 n/c					
4	Inspection Done Before Hardening By (Name)			Rao: ✓					
5	Material Sent For Hardening By (Name)			Lark Porroce					
6	Material Sent For Hardening On Date		7	6	25				
Inspected By (Sign) & Date				Rao: 7/6/25					

Reviewed by (Engineer-CNC)

Manager-QA