



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.		15194	39/5-1
2	Machined By		V. T. L. H/c Shop	Drg No. 103510
3	Pallet Die No.		13255 (B.5) H	
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	619.9 H Step 60.611.9 H	Step length 19.5
6	Inside Diameter	Drg. No.	52.14 H	
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	13+8+5 H / 13+8+5 H	
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	
13	Tapping Hole Diameter		H200 Check by H200 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 2.4 H	Tapping Depth 18.6 H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 Sinking
2	External Relief Dia	4.0 H	Outside (3-3)			Inner				Rev = 27
3	External Relief Depth		18 H			11 H				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Burnace
6	Material Sent For Hardening On Date									9 6 25

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA