



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.		15212 ✓	42/50
2	Machined By		V. T. L. H/C Shop	Drg. No. 18.0.31
3	Pallet Die No.		14313(6.0) H/C	Rev. 2.00
4	Die Category	Drg. No.	53310	
5	Out Side Diameter	Drg. No.	621 H/C, Step 00, 623.8 H/C	Tapper 12
6	Inside Diameter	Drg. No.	520.14 H/C	Step length 1.4 H/C
7	Width of Pellet Die	Drg. No.	186 H/C	
8	Grooves as per Drawing	Drg. No.	9x10x3 H/C 9x10x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	[Tapping H/C of Hole 12 Both Side]
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H16, Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 23.4 H/C	Tapping Depth 21.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 13/8/25

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 2.0
2	External Relief Dia	6.5 H/C	Outside (3-3)		Inner				Rev 18
3	External Relief Depth		14 H/C		8 H/C				
4	Inspection Done Before Hardening By (Name)		Sasi						
5	Material Sent For Hardening By (Name)		Lark Perma						
6	Material Sent For Hardening On Date		13	6	25				

Inspected By (Sign) & Date

Sasi 13/8/25

Reviewed by (Engineer-CNC)

Manager-QA