



Lark Engineering Company (India) Pvt. Ltd.

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

10143

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.		15207	4.0/42
2	Machined By		V.T.L. H/C Shop	Dr. H. (S.D.) 984
3	Pallet Die No.		15594 (5.0) H/C	Rev 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 H/C, Step 00 - 389 H/C	Step length 9.5
6	Inside Diameter	Drg. No.	315.14 H/C	
7	Width of Pellet Die	Drg. No.	145 H/C	
8	Grooves as per Drawing	Drg. No.	16 x 6 x 4 H/C / 16 x 8 x 4 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 Holes - 8 Bedu Side]
12	Tapping PCD		356 H/C	
13	Tapping Hole Diameter		Ø3/4" 2 Check by Ø3/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.6 H/C	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/6/25	
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	5.5 H/C	Outside (2-2)	Rev 2 14
3	External Relief Depth		5 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For more	
6	Material Sent For Hardening On Date		23 6 25	
Inspected By (Sign) & Date			Ravi 23/6/25	

Satish 23/6/25

Reviewed by (Engineer-CNC)

Manager-QA