



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15215	37/42/60
2	Machined By		V.T.L H/C Shop	Qty 12-2-654
3	Pallet Die No.		14923(6.0) H/C	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	719.9 H/C	Step 60 = 691.8 H/C Step length 19.5
6	Inside Diameter	Drg. No.	600.14 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	36x10x7 H/C	36x10x7 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		645 H/C	
13	Tapping Hole Diameter		H20 = 2 Groove by H20 B.12	
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 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 6.0
2	External Relief Dia	6.5 H/C	6.5 H/C	All Rows 2 23 H/C
3	External Relief Depth	7.0 H/C	7.0 H/C	All Rows 2 18 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permac	
6	Material Sent For Hardening On Date		23 6 25	
Inspected By (Sign) & Date			Ravi 23/6/25	

Reviewed by (Engineer-CNC)

Manager-QA