



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)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15405	38/40/109
2	Machined By		V.T.L. n/c Shop	Digital, Lark 1551
3	Pallet Die No.		15186 (4.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 n/c Shop 395 n/c	Step length 14.5
6	Inside Diameter	Drg. No.	320.14 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c 15.8 x 7 x 2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		355 n/c	of holes 8
13	Tapping Hole Diameter		M18, Check by M18 Ball	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 n/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/7/25

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

Counter. Ravi

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c	Outside 22-25		Inner				
3	External Relief Depth		6 n/c		Inner				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Lark				
6	Material Sent For Hardening On Date				4	7	25		

Inspected By (Sign) & Date

Ravi 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA