



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)

10167

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15270	55/55
2	Machined By		V. T. L. H/c Shop	Dy. 18.04.13
3	Pallet Die No.		15472 (4.0) H/c	Revol
4	Die Category	Drg. No.	790	
5	Out Side Diameter	Drg. No.	740 H/c Shop 80.743.4 H/c	Tapping 10.0
6	Inside Diameter	Drg. No.	630.14 H/c	Step length 99
7	Width of Pellet Die	Drg. No.	290.6 H/c	Under cut 1.75 H/c
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H/c / 15.3 x 8 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10	Drilling Area Surface Smoothness		OK	0.5 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		685 H/c	Tapping H/c
13	Tapping Hole Diameter		H20. Check by H/c B-11	of Holes 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/6/25

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

Counter 60
Low 40

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner		
3	External Relief Depth		5 H/c		Nil		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Resource		
6	Material Sent For Hardening On Date		28	6	25		

Inspected By (Sign) & Date

Ravi 28/6/25

Satyam 28/6/25

Reviewed by (Engineer-CNC)

Manager-QA