



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

10232

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15352 ✓	42/45
3	Pallet Die No.		V.T.L. H/c Shop	Drg. H. 12.0.125 G
4	Die Category	Drg. No.	15572 (G.O) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Senior ✓	
6	Inside Diameter	Drg. No.	509.9 H/c	492 H/c
7	Width of Pellet Die	Drg. No.	420.14 H/c	492 H/c
8	Grooves as per Drawing	Drg. No.	152 H/c	492 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	1175 x 3 H/c	1175 x 3 H/c
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		456 H/c	
13	Tapping Hole Diameter		0.914" 2 Check by 0.914" Ball	Tapping H/c of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.5 H/c	Tapping Depth 14.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/25

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

1	Counter Sinking Depth & Finish	OK							Counter 60°
2	External Relief Dia	6.5 H/c	82-85		Inner				Rep. 15
3	External Relief Depth		9 H/c		3 H/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Ferraro				
6	Material Sent For Hardening On Date				8	7	25		

Inspected By (Sign) & Date

Ravi 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA