



Lark Engineering Company (India) Pvt. Ltd.

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

10210

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.			
2	Machined By		15341	40/60
3	Pallet Die No.		V.T.L. H/C Shop	Dr. H. 18.0.1361
4	Die Category	Drg. No.	14747 (5.0) H/C	Rev. 2.00
5	Out Side Diameter	Drg. No.	M 740	
6	Inside Diameter	Drg. No.	719.9 H/C Shop	Step length 19.8
7	Width of Pellet Die	Drg. No.	600.14 H/C	
8	Grooves as per Drawing	Drg. No.	265.6 H/C	Fore side 360
9	Fitting Sizes on CNC Plate	Drg. No.	15.328 x 7 H/C / 15.328 x 7 H/C	0.8 mm Deep
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M20 Check by M20 Ball	Tapping H. of 4.12 = 12
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 18.0
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 35
2	External Relief Dia	5.5 H/C	Outside (3.3)		Inner			
3	External Relief Depth		2.5 H/C		2.0 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		2	2	25			

Inspected By (Sign) & Date

Ravi 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA