



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15388 ✓	36/45 ✓
3	Pallet Die No.		V. T. L. H/c Shop	Drg No. 12.02 579
4	Die Category	Drg. No.	12904 (3.07) H/c	Renew ✓
5	Out Side Diameter	Drg. No.	8.10 H/c	Step 002 615.4 H/c Tappet. 4
6	Inside Diameter	Drg. No.	5.20.14 H/c	Step length 1.8 H/c
7	Width of Pellet Die	Drg. No.	2.22 H/c	Under cut. 2.75 H/c
8	Grooves as per Drawing	Drg. No.	13.8 H/c 5 H/c / 13.8 H/c 5 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		56.5 H/c	Tapping H/c of holes 12
13	Tapping Hole Diameter		H20. Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 H/c	Tapping Depth. 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 11/7/25	
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	3.5 H/c	20.5 H/c 3-3.5	Inner 9 H/c
3	External Relief Depth		15 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnore	
6	Material Sent For Hardening On Date		11 7 25	
Inspected By (Sign) & Date			Ravi 11/7/25	

Reviewed by (Engineer-CNC)

Manager-QA