



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		14950	53/58
3	Pallet Die No.		N.T.L. Hla Shop	Day 21.1.12.2013
4	Die Category	Drg. No.	15905 (3.8) mm	Rev 2.00
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	636 mm Step 00.612 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.14 mm	
8	Grooves as per Drawing	Drg. No.	254 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm / 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		Hla Shop	
13	Tapping Hole Diameter		565 mm	
14	Tapping On Second Side	Half pitch of 1st side	120. Check by Hla Ball	Tapping 2nd of holes. 12 Ball Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 mm	Tapping Depth 18.0
17	Visual Inspection Before Gun Drilling		Yes ok	
Inspected By (Sign) & Date			Ravi 9/7/25	
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		Counters 60°
2	External Relief Dia	4.3 mm	Outside (2.3-3)	Inner
3	External Relief Depth		12 mm	5 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		9 7 25	
Inspected By (Sign) & Date			Ravi 9/7/25	

Reviewed by (Engineer-CNC)

Manager-QA