



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.		15502	37/50
2	Machined By		V.T.L. H/c Shop	Drill Holes 1.80 998
3	Pallet Die No.		14712 (4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Ext. side	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step OP. Tappet 12
6	Inside Diameter	Drg. No.	5.20 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	9.20 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 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	
13	Tapping Hole Diameter		H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/7/25	
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		
2	External Relief Dia	4.5mm	outside (3.3)	Inner
3	External Relief Depth		17mm	13mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Rurnore	
6	Material Sent For Hardening On Date		15 7 25	
Inspected By (Sign) & Date			Ravi 15/7/25	

Reviewed by (Engineer-CNC)

Manager-QA